

Date: Wednesday, 10/10/2007 11:02:51 AM  
 User: Kim Johnston

## Process Sheet

46

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD ASSEMBLY RH  
 Job Number : 35071  
 Estimate Number : 10799  
 P.O. Number : N/A Part Number : D350600142  
 This Issue : 10/10/2007 S.O. No. : N/A Drawing Number : IIN REV.C PG11,18-21  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C  
 Previous Run : 33437 Material : N/A  
 Due Date : 11/15/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JS 07 10 10  
 Comment : Est Rev:D 05.04.14 Incorporated procedures from D3187-1/-2 K  
 J/JLM  
 Est Rev:E 06-11-20 As per DSI9335 JLM  
 est rev F 07.02.07 iin rev.c ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS07.1015 (1)

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG003

54/12/12

2.0 35071A SWITCH RELOCATION KIT



Comment: Sub-Component SWITCH RELOCATION KIT

1 x D350-600-349 B 34742

3.0 35071B SPACEPOD BODY RH



Comment: Sub-Component SPACEPOD BODY RH

D3188-2M Batch: 35071B

ml07/12/07

4.0 35071C SPACEPOD DOOR RH



Comment: Sub-Component SPACEPOD DOOR LH

D3186-2 B 35071C

ml07/12/07

5.0 D31872 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3187-2	Floor	<u>331836</u>
1	D3186-2	Door (ref)	<u>35071C</u>
1	D3188-2M	Body(ref)	<u>35071B</u>

JS

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Job Number: 35071

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch  
28 ALS4-1032-130 Insert M105730

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open holes in D3188-2 body floor to Ø0.297".

2-Install inserts in D3188-2 as per Dwg D3188.

*ml 07/12/07*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*6 2/12/07*

9.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

Pick:

✓ Qty Part Number Description Batch  
5.62SF D2986 Neoprene Foam B 30632

*ml 07/12/07*

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T2

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement Batch: M102565

*ml 07/12/10*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*6 4/12/10 @*

12.0

AN3235020935

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

\* WASHER

batch: M106150

*PS*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 35071

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D35672

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓

DECAL

batch: B31128



14.0

MS20426AD45

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

✓

Pick:

Batch: M3459



15.0

D35491

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓

BRACKET

batch: B31125



16.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓

Pick:

Batch: B33486



17.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓

BALL STUD

batch: B30210



18.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓

Pick:

Batch: M104156



19.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓

Pick:

Batch: B34197



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 35071

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS20426AD46

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Rivet

Batch: M103395



21.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ HINGE BRACKET

batch: B35454



22.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Pick:

Batch: B30630



23.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓ Screw

batch: M9216



24.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓ Washer

batch: M105057



25.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓ Nut

batch: M105430



26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-2 floor with D3188-2 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for body & floor\*\*\*\*

N/A ml  
07/12/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 35071

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D35529

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ CARBON STEEL GAS SPRING  
batch: B 30673

28.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Screw  
batch: M104427

29.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓ Washer  
batch: M105057

30.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Washer  
batch: M105164

31.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Nut  
batch: M105430

32.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

✓ 3/4 Seal  
Cut 127.00" long batch: B30681

33.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ Door Latch  
batch: B 35802

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 35071

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D2585

Latch Clamp



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓

Latch Clamp

batch: B33487

35.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓

Latch Plate

batch: B32355

36.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓

Screw

batch: M105108

37.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓

Washer

batch: M105792

38.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓

Nut

batch: M105558

39.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓

Hinge Bracket

batch: B33942

40.0

D2228

Backing Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓

Backing Plate

batch: B30679

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 35071

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

✓ Screw

batch: M104603

42.0

AN960JD8

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

✓ Washer

batch: M105057

43.0

MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

✓ Nut

batch: M105430

44.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Hinge Bracket

batch: B33453

45.0

D35481

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ BRACKET

batch: B30245

46.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ BALL STUD

batch: B30210

47.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Washer

batch: M104156

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 35071

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: 334197

49.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

50.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

51.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M 106030

52.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

53.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

1335093

1 D3187-1(Ref)

Spacepod Floor

31836

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 35071

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-142

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

B

AS 07/12/12

(X)

56.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



607.12-13

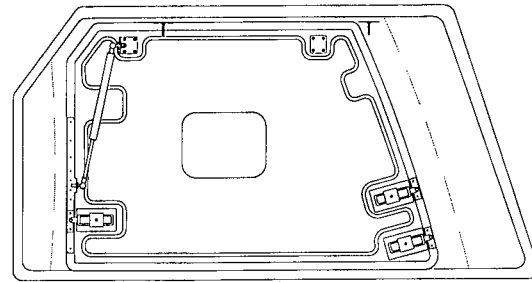
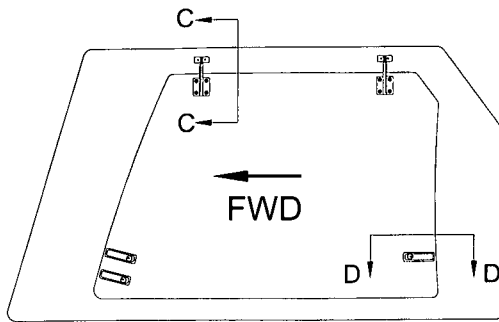
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

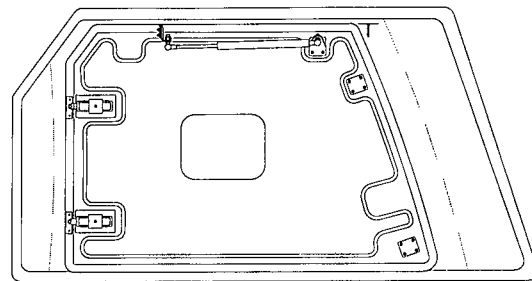
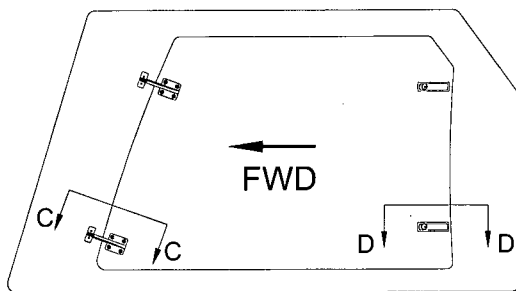
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

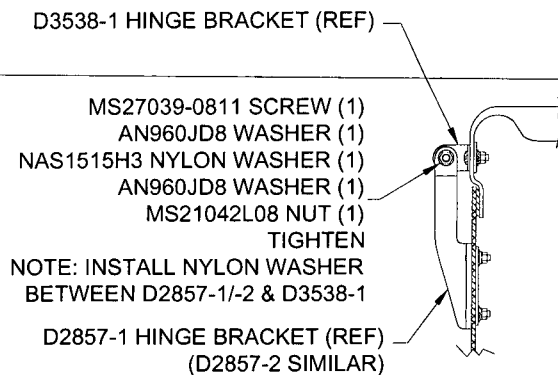
**NOTE:** Date & initial all entries



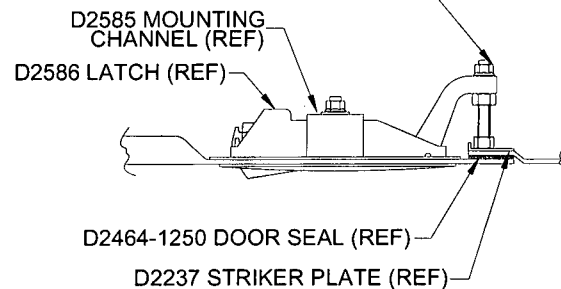
**FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



**FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



ADJUST SCREW TO ENSURE  
COMPRESSION OF DOOR SEAL  
AND LOCK IN POSITION WITH NUT



**SECTION 'C-C' HINGE**  
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)

**SECTION 'D-D' LATCH**

3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:

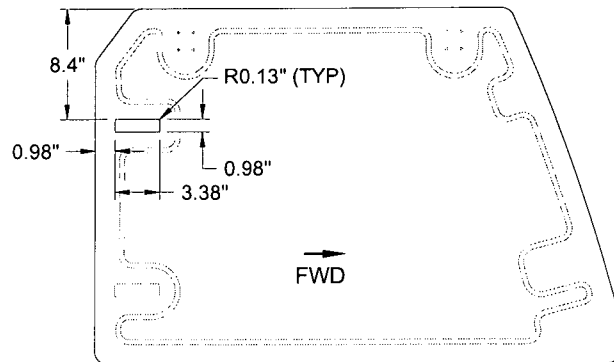
- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
- If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
- Re-install the belly panel per the Aircraft Maintenance Manual.

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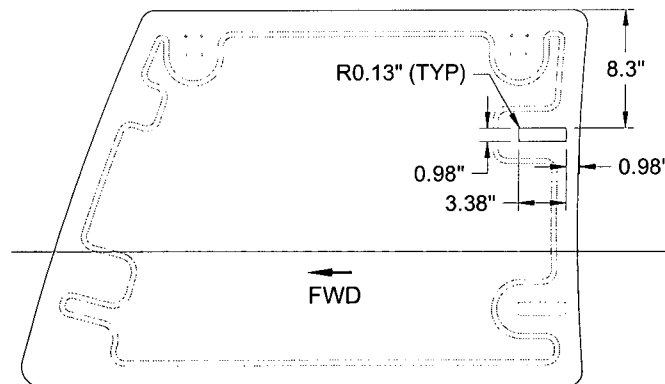
Revision: **C**  
Date: 07.02.20

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35071

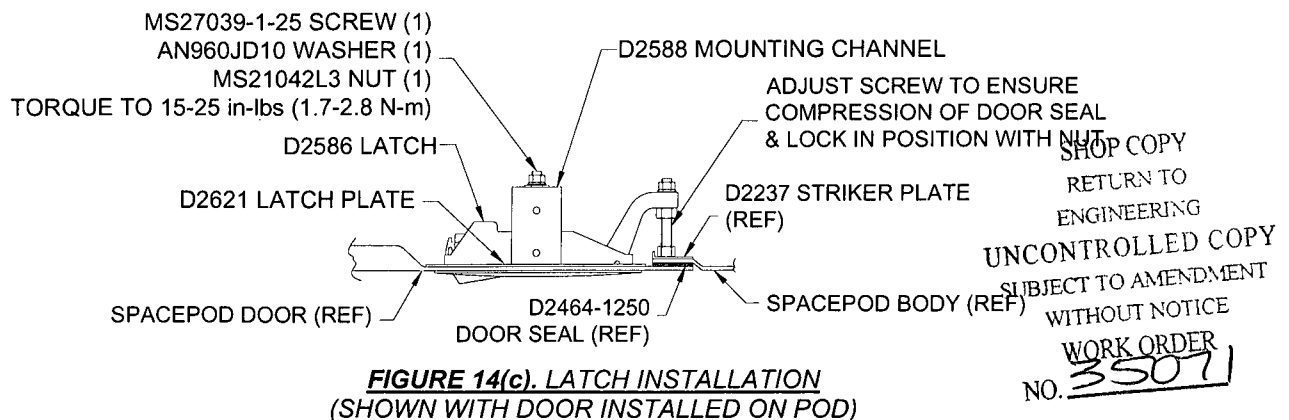
- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).



**FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT**  
(APPLICABLE FOR -041I-043I-141I-143 KITS)



**FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT**  
(APPLICABLE FOR -042I-142 KITS)

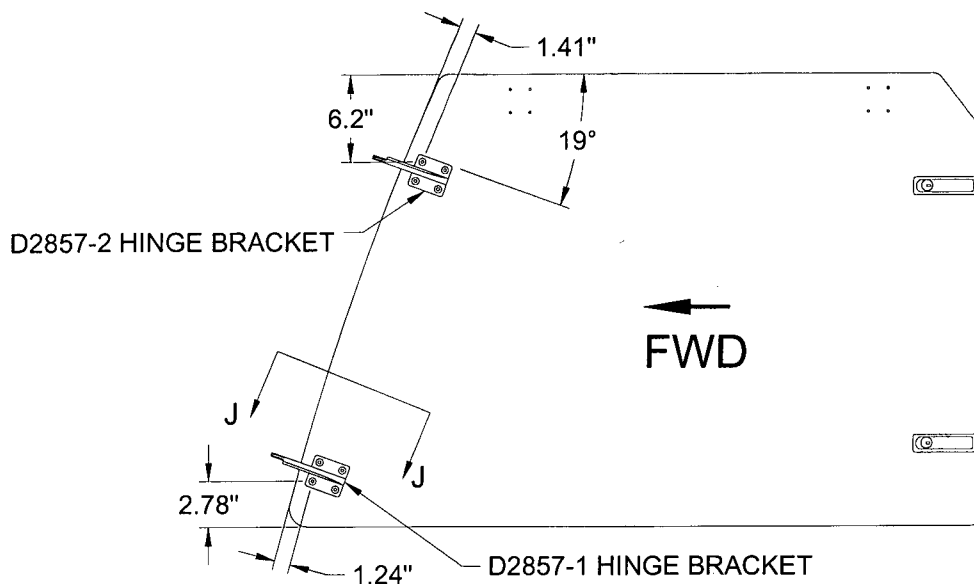


**FIGURE 14(c). LATCH INSTALLATION**  
(SHOWN WITH DOOR INSTALLED ON POD)

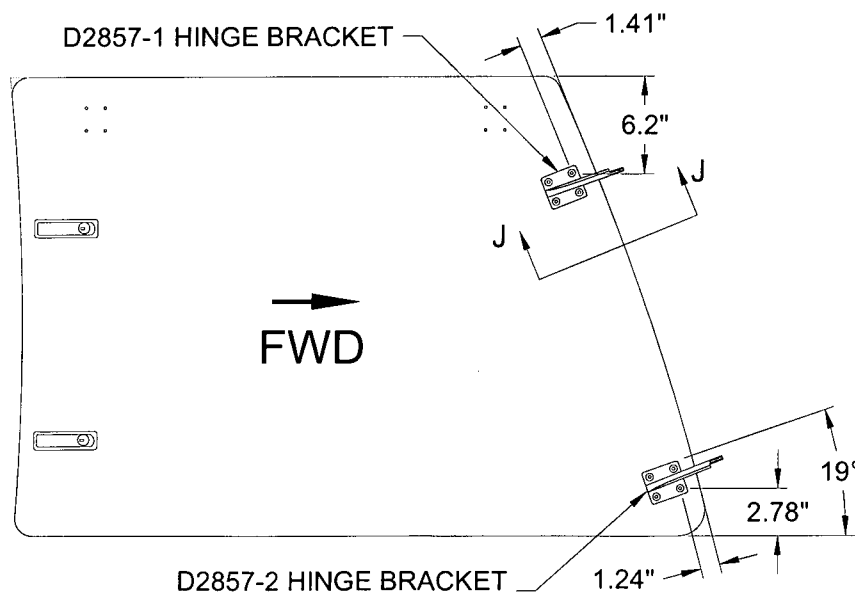
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Revision: **C**  
Date: 07.02.20

- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the  $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

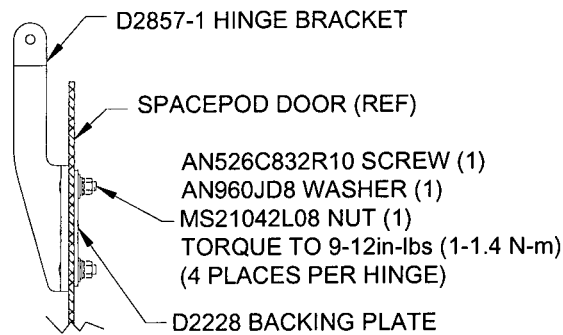


**FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR**



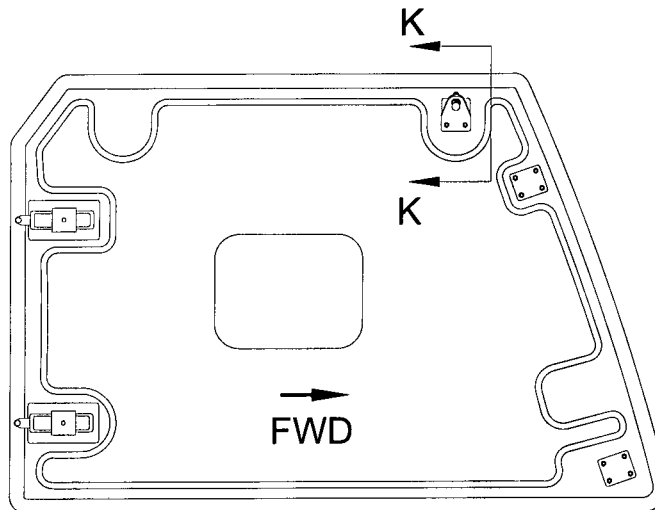
**FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR**

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WITHOUT NOTICE  
WORK ORDER  
NO. 35071

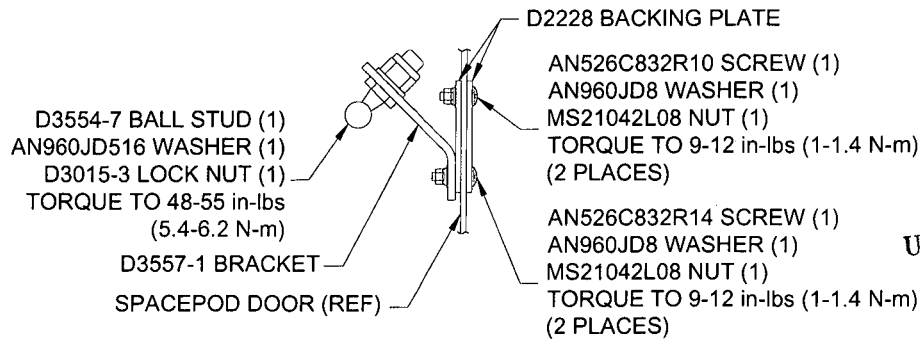


**SECTION 'J-J' HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.



**FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR**  
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



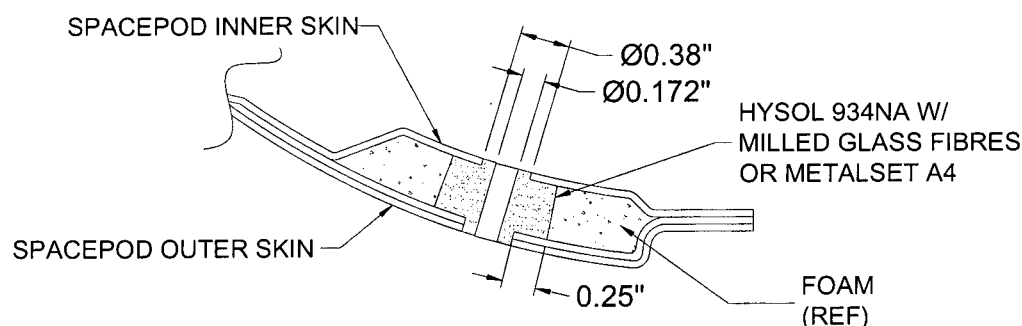
**SECTION 'K-K'**

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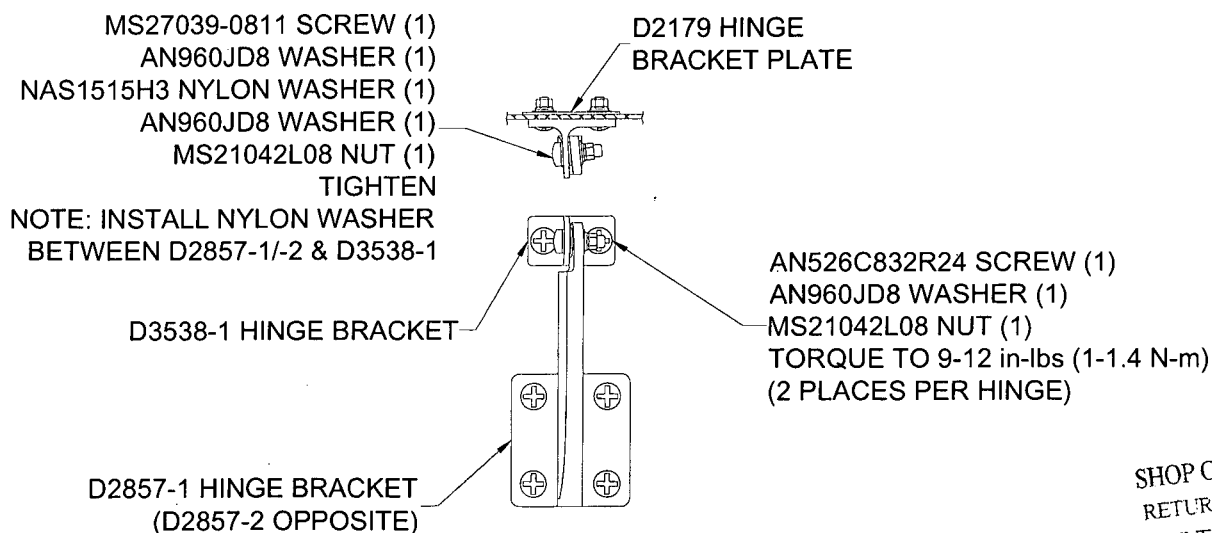
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NO. 35071

Revision: C  
Date: 07.02.20

- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
  - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
  - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
  - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
  - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).



**FIGURE 17(a). COMPOSITE MODIFICATION**



**FIGURE 17(b). HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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NO. 35071

Date: Wednesday, 10/10/2007 11:03:01 AM  
 User: Kim Johnston

## Process Sheet

46

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR RH
Job Number : 35071C	
Estimate Number : 11099	
P.O. Number :	Part Number : D31862
This Issue : 10/10/2007 S.O. No. :	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : D
Previous Run : 33437C	Material :
Written By :	Due Date : 11/15/2007 Qty: 1 Um: Each
Checked & Approved By : <u>10/10/07</u>	
Comment : Est Rev: A New Issue 05-11-29 JLM est rev B rev D dwg EC 07.03.07	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	35071C01	SPACEPOD DOOR RH
-----	----------	------------------



Comment: Sub-Component SPACEPOD DOOR RH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-2 detail)

ml 07/12/07 x1

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

ml 07/12/07

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6A

ml 07/12/07 x1

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

ml 07/12/13 ①

Job Completion



ml 07/12/13



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



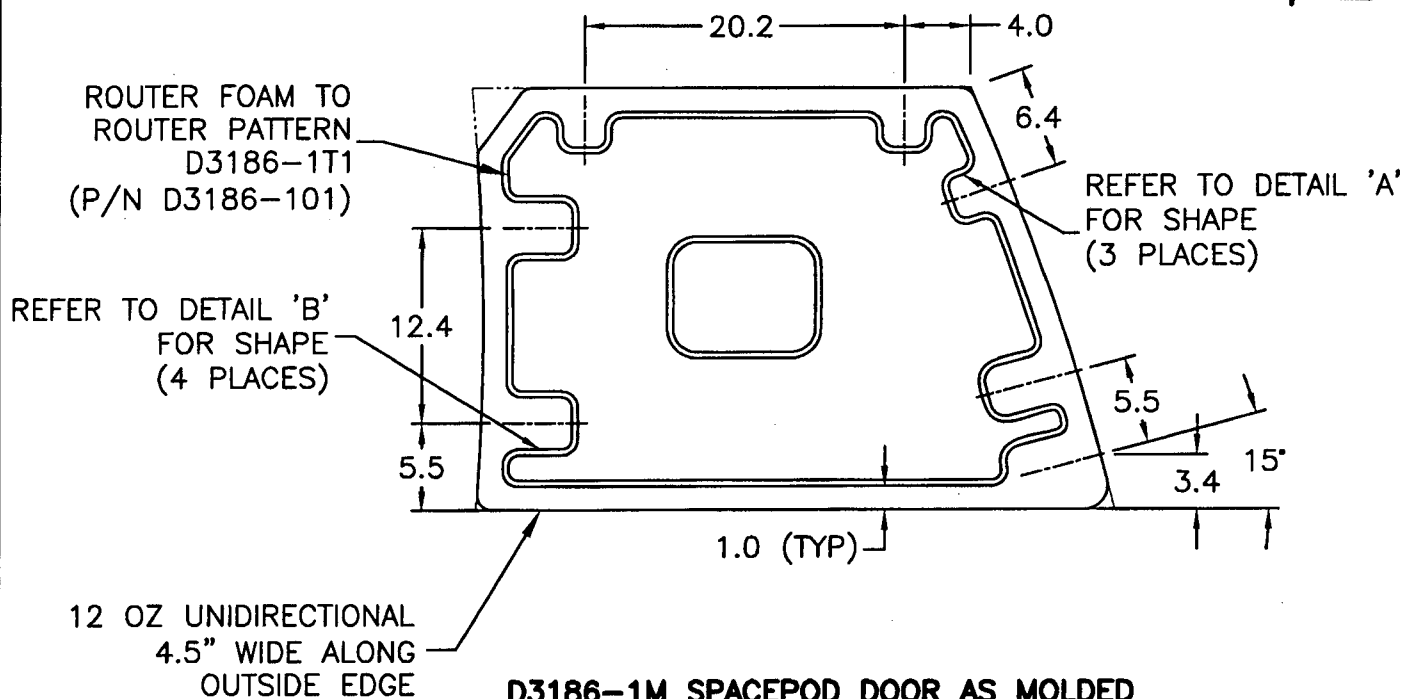
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

#### MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

RELEASED

07.02.27



**D3186-1M SPACEPOD DOOR AS MOLDED**

#### NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERA KANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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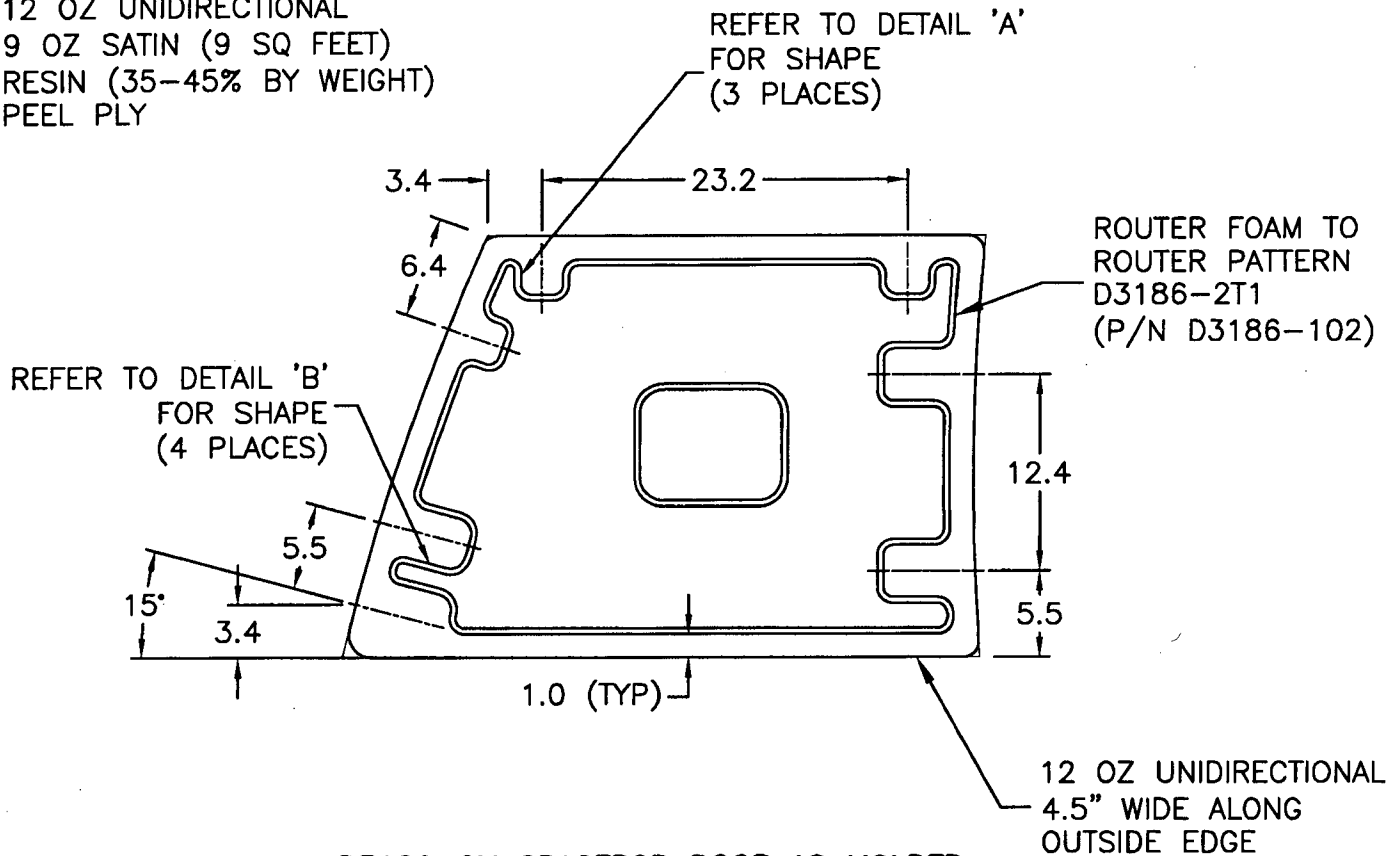
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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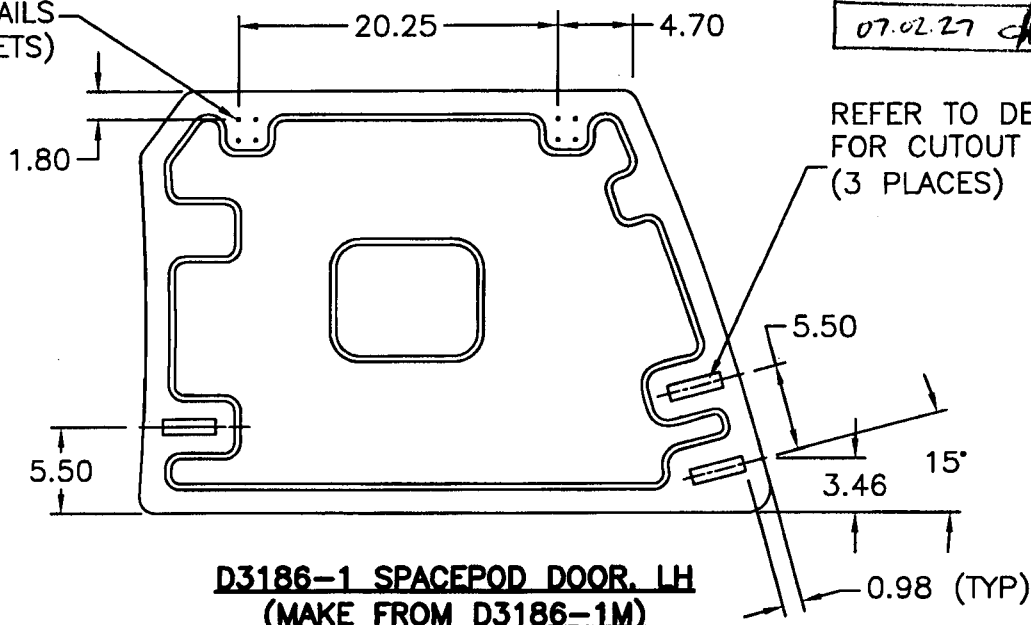
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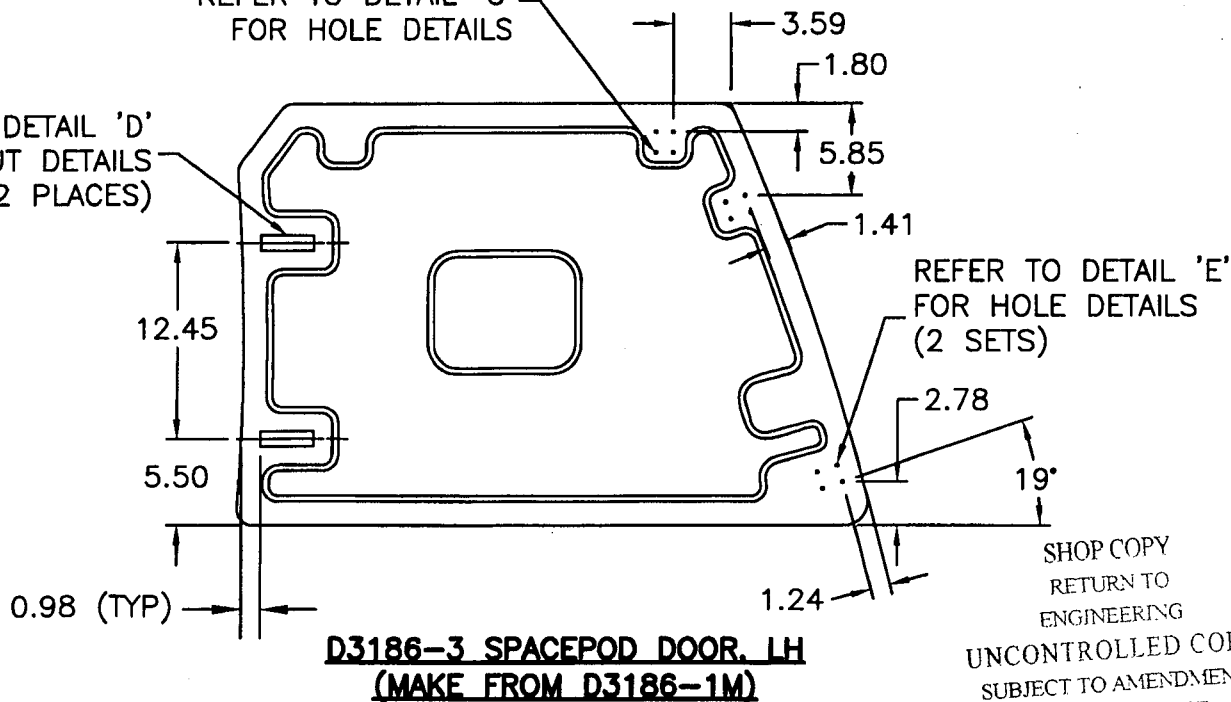
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



REFER TO DETAIL 'C'  
FOR HOLE DETAILS

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)



**NOTES:**

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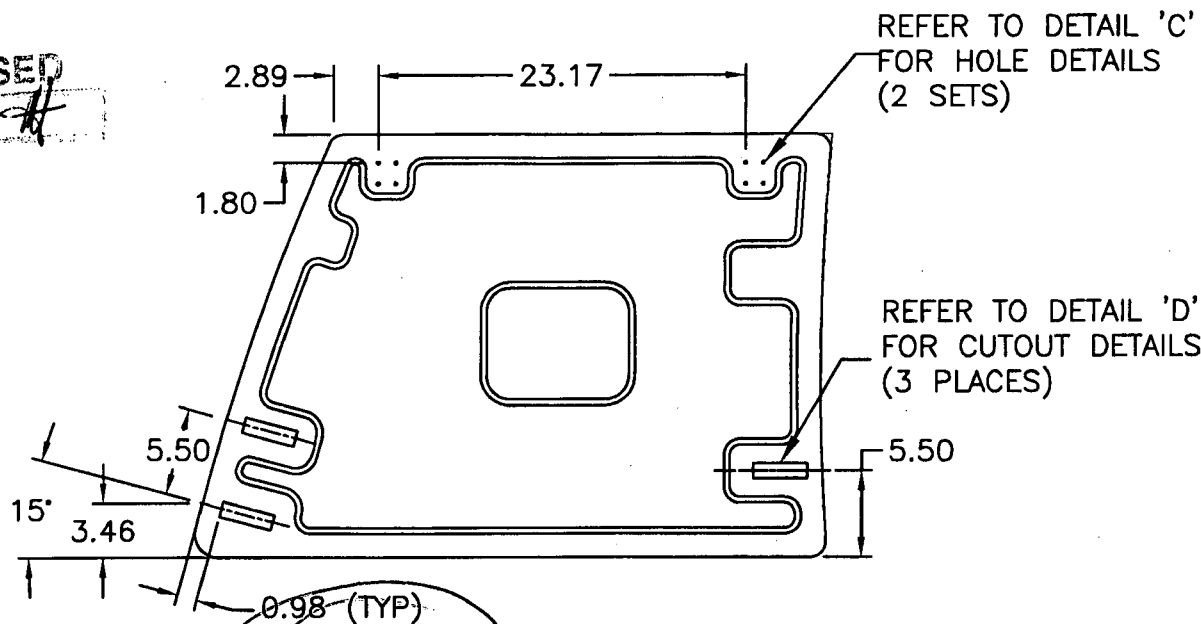
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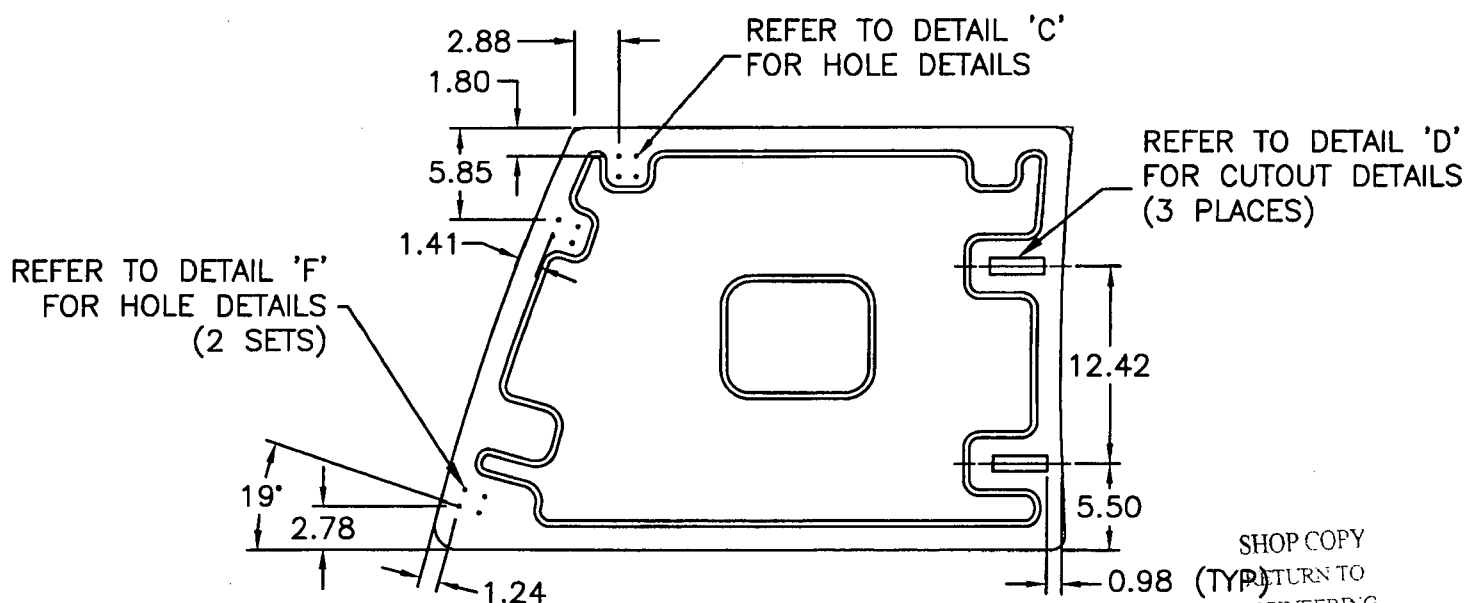


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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED  
07-02-27



**D3186-2 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

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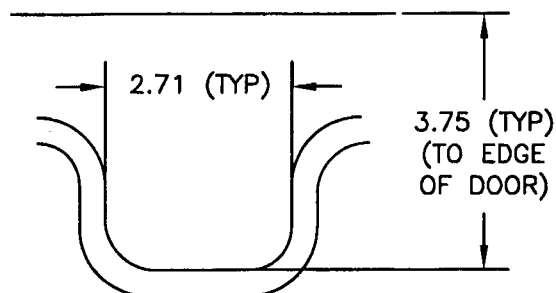
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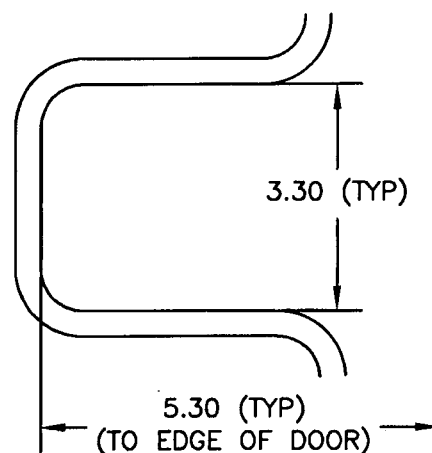
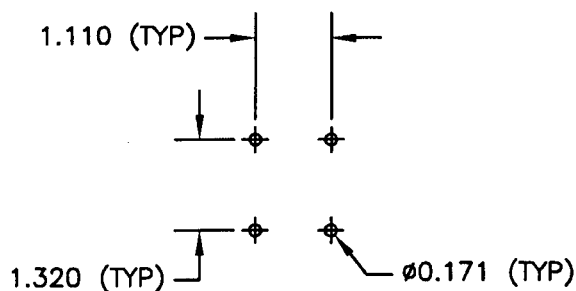
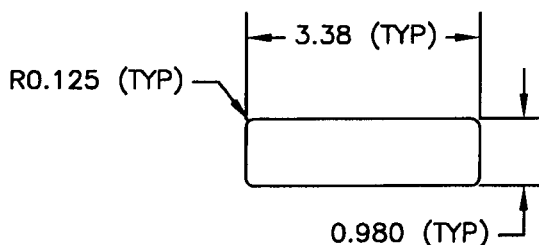
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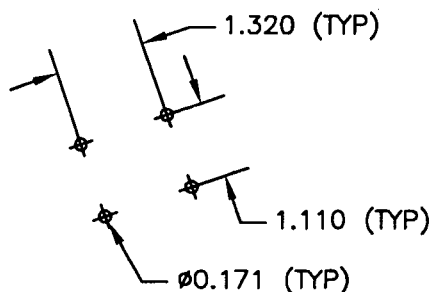
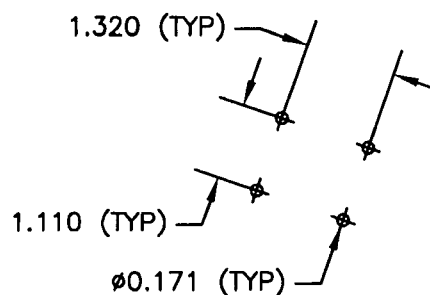
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.27 [Signature]

**DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D****DETAIL E****DETAIL F****NOTES:**

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Canada \*\*Fax (514) 533-4494 \*\*

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice #	12250-A
Customer #	DART

Telephone: (514) 533-5788  
Warehouse: MAIN

Bill to:

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1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-622-5200  
Contact: Linda Lavelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net 30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Order by	Your PO #	GST/PST #	
15 JUL 2007	11 10 2007	5502	Chantal Lavoie		PD00004784		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0053	D31881M Spacepod Body LH B35070B Dwg Rev: B Job: 42160			
1	0	1	DKC134-0052	D31861M Spacepod Door LH B35070C01 Dwg Rev: D Job: 42140			
1	0	1	DKC134-0054	D31862M Spacepod Door RH B35070C01 Dwg Rev: D Job: 42155			
1	0	1	DKC134-0055	D31882M Spacepod Body RH B35071B Dwg Rev: E Job: 42166			
							WB #129-001-560-647-854
							U de M: Each
							U de M: Each
							U de M: Each
							U de M: Each

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by: André St. Louis  
Quality department AQ-557



Date: Wednesday, 10/10/2007 11:03:03 AM  
User: Kim Johnston

# Process Sheet

46

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 35071C01		
Estimate Number	: 12599		
P.O. Number	:	Part Number	: D31862M
This Issue	: 10/10/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 33439B01	Material	:
Written By	:	Due Date	: 11/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev:A New Issue 06-12-04 ec est rev B rev D dwg 07.03.07 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
Issue P/O: 4784 C267110111  
Description: D3186-2M Door  
Supplier: Delastek  
Conformity Certificate and Process sheet required  
Ship 3 Items from Previous steps

2.0	D31862P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK  
Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: GA

m/07/12/06



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

Date: Wednesday, 10/10/2007 11:03:03 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 35071C01

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20/12/13

Job Completion



U 07.12.13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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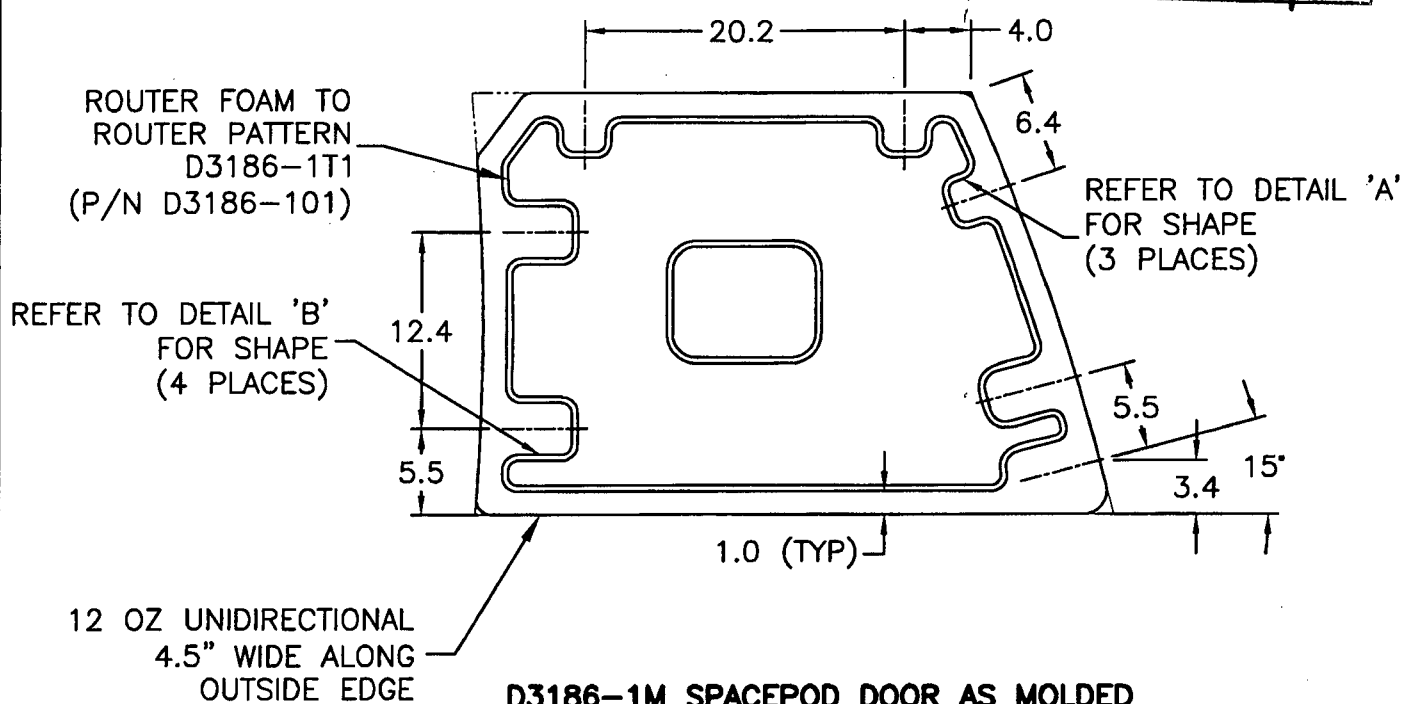
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

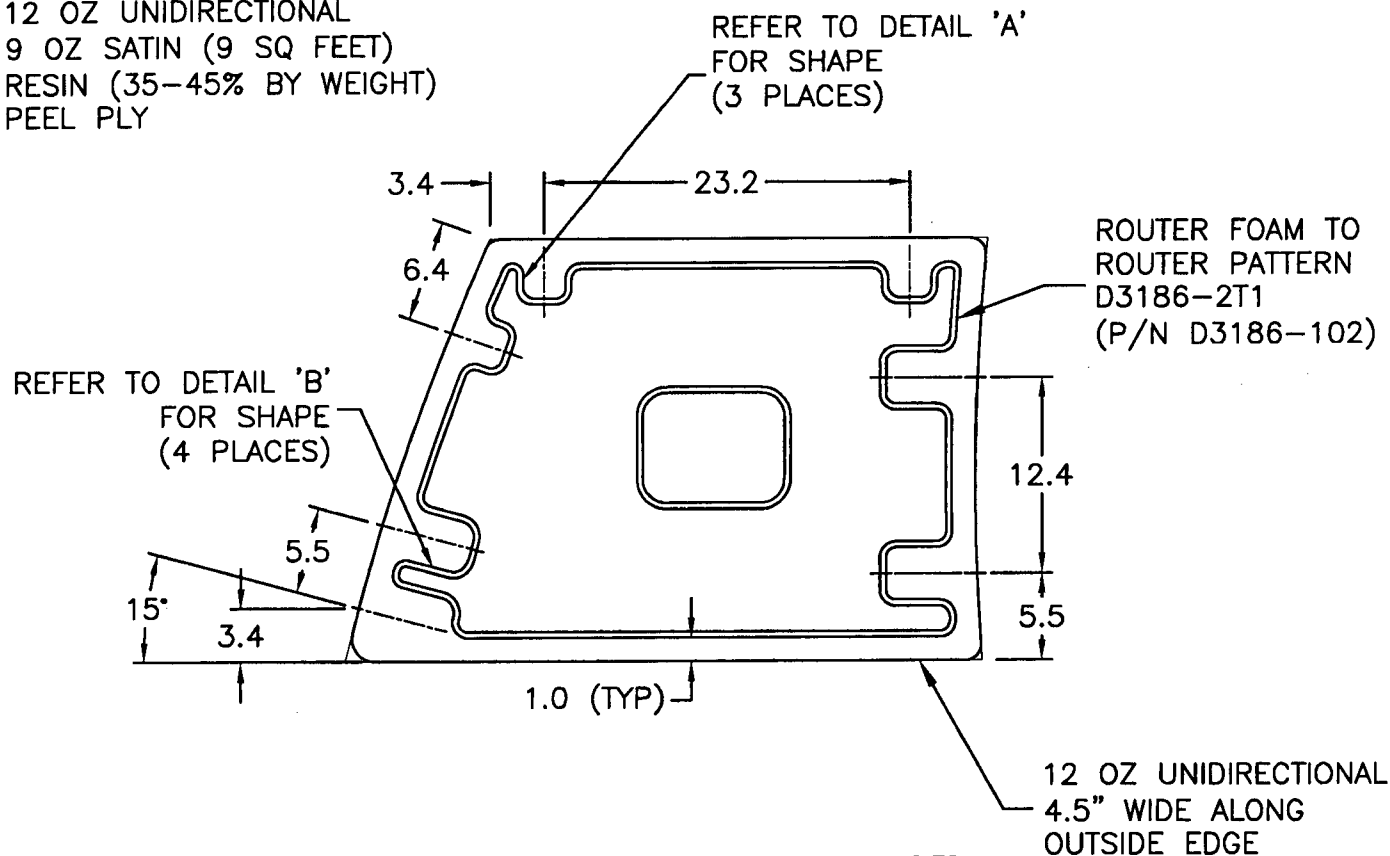
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.22

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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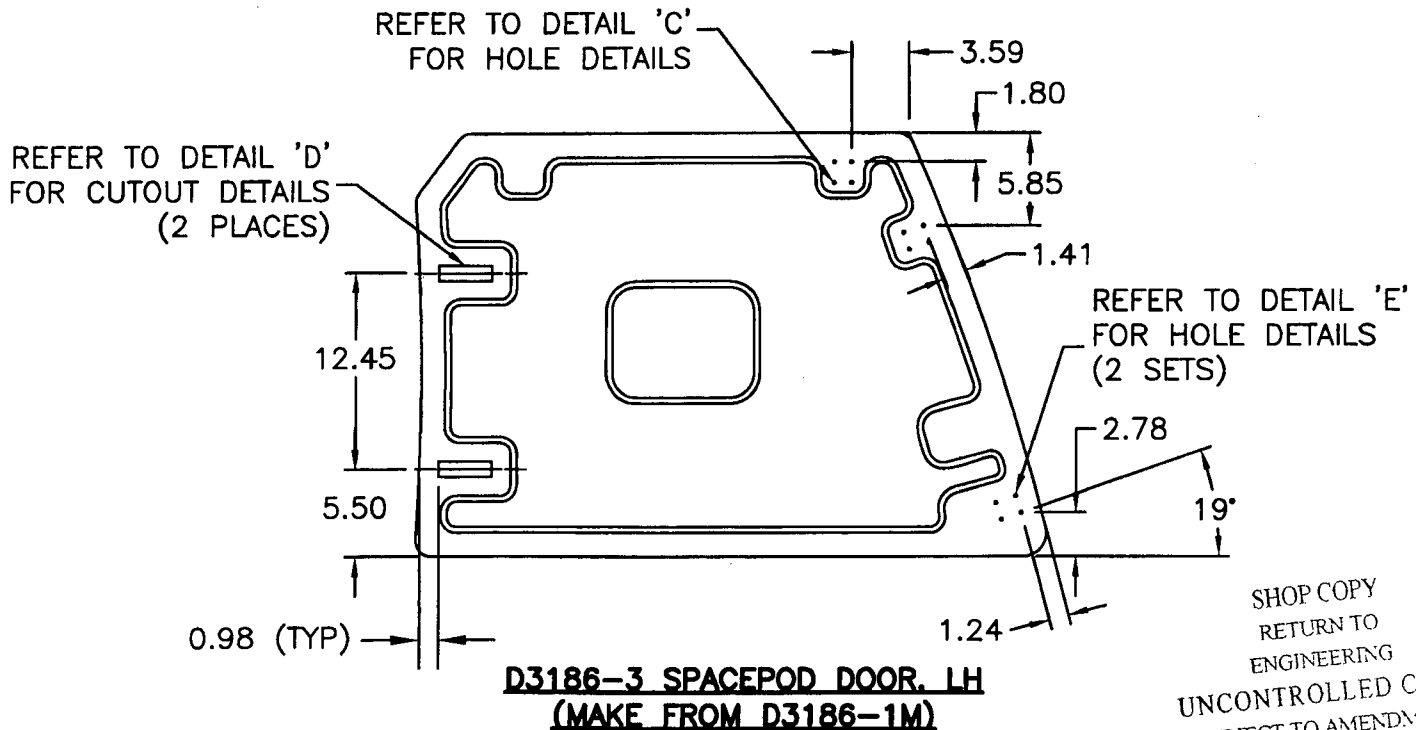
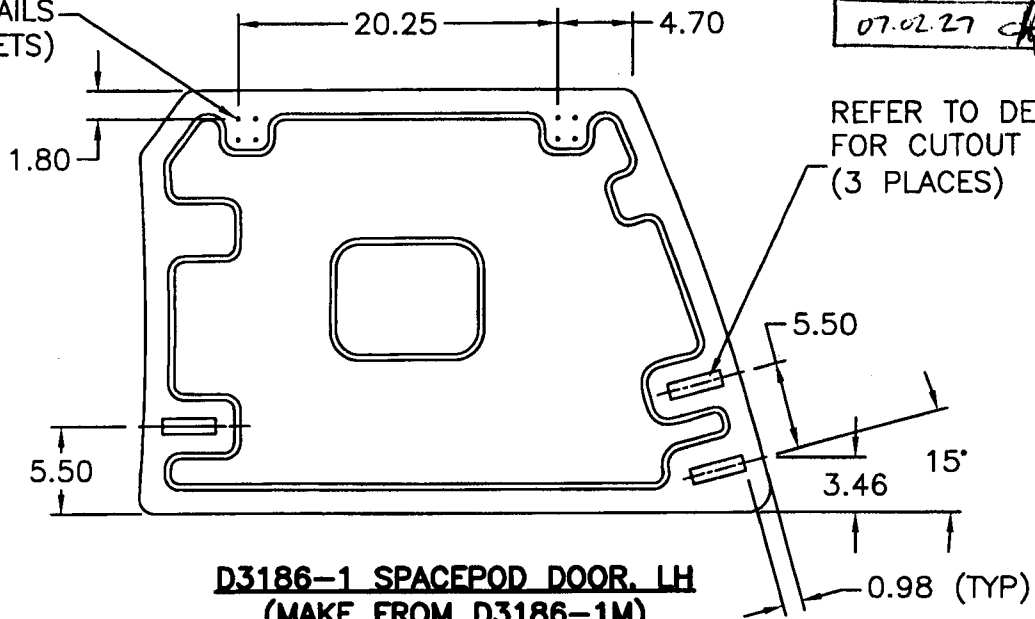
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
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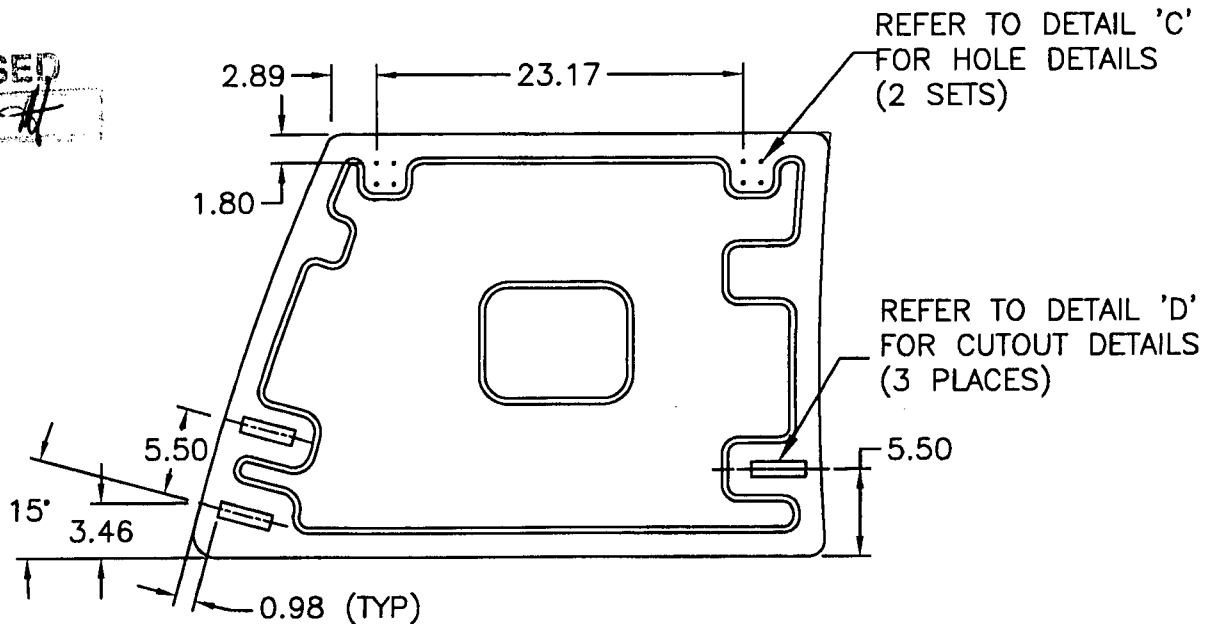
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**DART**

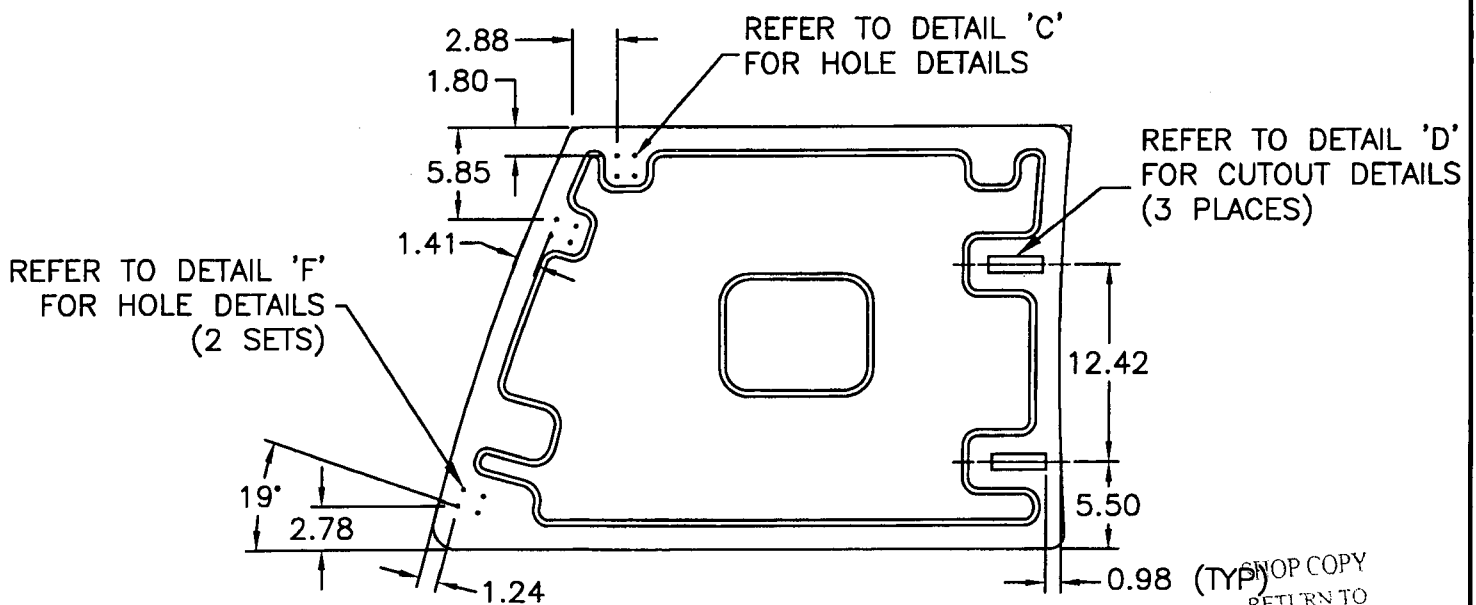
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

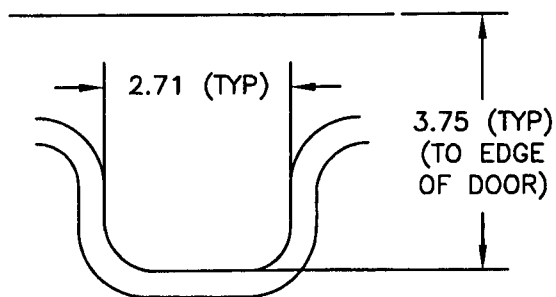
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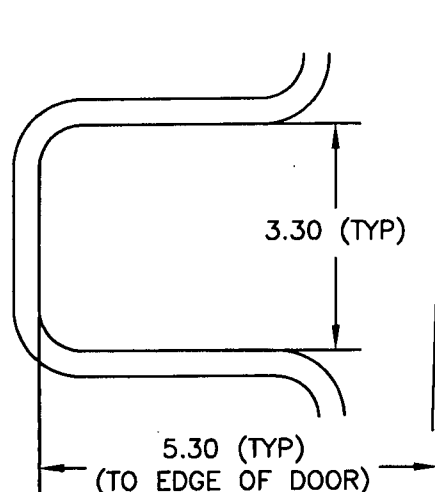
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



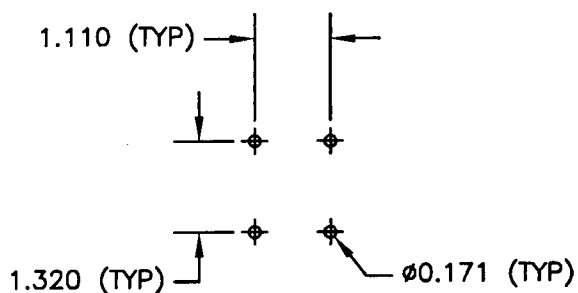
**DETAIL A**



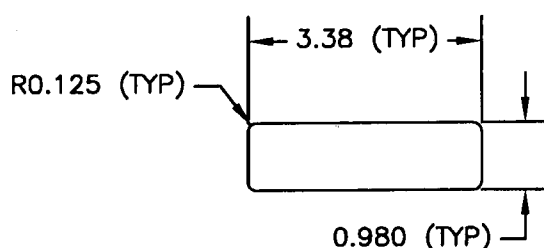
**DETAIL B**

RELEASED

07.02.27 [Signature]

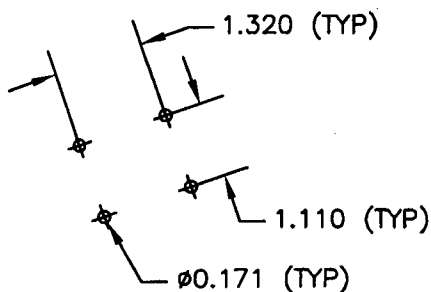


**DETAIL C**

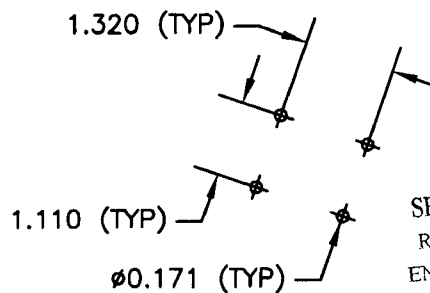


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

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**NOTES:**

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Date: Vendredi, 2007-09-14 14:11:51  
 Utilisateur: Marc Dubé


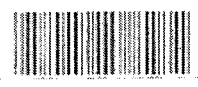

## Feuille de Procédé

Client	: DART Dart Aerospace Ltd.	Nom Dessin	: SPACEPOD DOOR
Numéro Job	: 42165	Numéro Article	: DKC134-0054
Numéro Soumission	: 2585	Numéro Dessin	: D3186
Numéro B.A.	:	Projet Numéro	: DKC134
Cette fois	: 2007-09-14 No. B.V. :	Révision dessin	: <input checked="" type="checkbox"/> D
Prsht Rev.	: NC	Matériel	: Fibre 7781 et Résine 411-350
Prem. fois	: - - Type :	Date Dûe	: 2007-09-21 Qté: 1 UDM: UNITE
Job précédente	: 42142		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Dart Aerospace : D31862M		

Process Sheet Rev.: 02 Ajouter une séquence d'emballage et une séquence d'inspection du positionnement de foam Core

Produit additionnel

Numéro Job: 

# Ség.	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
 		
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE  Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006  Date: <u>SEP 24 2007</u> Heure Début: <u>8:00</u> Heure Fin: <u>9:00</u> Sceau: 		
3.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) Feutre de drainage N° Airweave N 10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) Stretchlon 200 poche à vide Vert		

Date: Vendred, 2007-09-14 14:11:52  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42165

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Seq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish
Commentair Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s) 9.7 oz Weave #FG-778150-125Y Volan Finish #LOT: 1-6219-1		
8.0	AAC0443	Fiberglass 12 oz Unidirectional
Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s) Fiberglass 12 oz Unidirectional N° de Lot: 1-6170-3		
9.0	AAC0098	Ruban à gommer jaune #: T/AT-200Y
Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s) Ruban à gommer jaune #: T/AT-200Y		

10.0 PREPARATION 3 PREPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le côté non en contact avec le sac à vide

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 7/09/07 Heure Début: 8:00 Heure Fin: 10:00 Sceau: 32

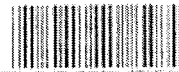
11.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)  
Catalyst N° DDM-9 N° de Lot: 1-6118-3

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-6330-1

13.0 PREPARATION 3 PREPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: SEP 24 2007 Heure Début: 1:55 Heure Fin: 2:00 Sceau: 34

Date: Vendredi, 2007-09-14 14:11:52  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42165

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Seq.: Machine ou Opération: Description:

14.0

LAMINAGE

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz

Recommencer l'opération pour le deuxième pli.

Date: SEP 26 2007

Heure Début: 2:00

Heure Fin: 2:15

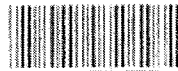
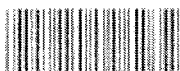
Sceau:



15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

EFFECTUER LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: SEP 26 2007

Heure Début: 2:15

Heure Fin: 2:25

Sceau:



Curing Début: 2:00 Curing Fin: 8:00

16.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0120 PINTE(s)/Unit Total: 0.0120 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6118-3

17.0

AAC0324

Résine (411B7530) 411-350 promo 75min

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo 75min.

N° de Lot: 1-6330

Date: Vendredi 2007-09-14 14:11:52  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42155

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description:

18.0

PREPARATION 3

PREPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heure.

Date: SEP 24 2007

Heure Début: 2:25 Heure Fin: 2:40 Sceau:



19.0

AAC0452

Polybond B46F

Commentair Qty.: 0.082 KIT(s)/Unit Total: 0.082 KIT(s)  
Polybond B46F N° de Lot: 16253-1

20.0

DKC134-0057

Foam Core N° D3186-102 ( Porte D3186-2 )

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Foam Core N° D3186-102 ( Porte D3186-2 )

N° de Job: 42017

21.0

ASSEMBLAGE 3

ASSEMBLAGE GENERALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DES PIÉCES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirer le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )

Faire l'inspection du positionnement par le département de la qualité

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_ Initiales: \_\_\_\_\_

N/A



Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.







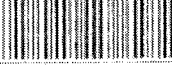

Date: SEP 25 2007

Heure Début: 12:40 Heure Fin: 1:10 Sceau:





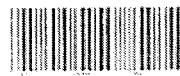


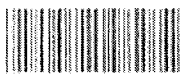
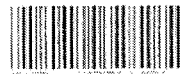


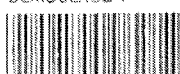


Date: Vendredi, 2007-09-14 14:11:52  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 42165		Numéro Article: DKC134-0054	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
22.0	POCHE A VIDE 1	FAIRE LA POCHE A VIDE	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs EFFECTUER LA POCHE A VIDE</p> <p>Faire la poche à vide en appliquant les composantes dans l'ordre suivant:</p> <ul style="list-style-type: none"><li>1- Tissu à délaminer</li><li>2- Feutre de drainage</li><li>3- Sac à vide Stretchlon 200</li></ul> <p>Laisser sécher pendant 2 heures minimum.</p> <p>Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1heure 1/2 ) afin d'enlever le surplus de polybond</p> <p>Date: <u>25-09-07</u> Heure Début: <u>1:10</u> Heure Fin: <u>1:20</u> Sceau:  </p> <p>Curing Début: <u>1:10</u> Curing Fin: <u>8:00</u></p>			
23.0	AAC0275	Catalyst N° DDM-9	
<p>Commentaire Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s) Catalyst N° DDM-9</p> <p>N° de Lot: <u>1-6118-3</u></p>			
24.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<p>Commentaire Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.</p> <p>N° de Lot: <u>1-6330-1</u></p>			
25.0	PRÉPARATION 3	PRÉPARATION DU MATERIEL DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL</p> <p>Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.</p> <p>Date: <u>SEP 26 2007</u> Heure Début: <u>3:15</u> Heure Fin: <u>3:25</u> Sceau: </p>			

Date: Vendredi, 2007-09-14 14:11:52  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.	Nom Dessin: SPACEPOD DOOR	
Numéro Job: 42165	Numéro Article: DKC134-0054	
Numéro Job: 		
# Séq.: 26 0	Machine ou Opération: LAMINAGE	Description: LAMINAGE PIECE DART
 		
<p>Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs FAIRE LE LAMINAGE DES TISSUS</p> <p>Faire le laminage d'un pli de 9.7 oz</p> <p>Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.</p> <p>Faire le laminage du dernier pli de 9.7 oz.</p> <p>Date: <u>SEP 26 2007</u> Heure Début: <u>3:25</u> Heure Fin: <u>4:10</u> Sceau:  </p>		
# Séq.: 27 0	Machine ou Opération: POCHÉ À VIDE 1	Description: FAIRE LA POCHÉ À VIDE
 		
<p>Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs EFFECTUER LA POCHÉ A VIDE</p> <p>Faire la poche à vide en appliquant les composantes dans l'ordre suivant:</p> <ul style="list-style-type: none"><li>1- Tissu à délaminer,</li><li>2- Film perforé P-3,</li><li>3- Feutre de drainage</li><li>4- Sac à vide Stretchlon 200</li></ul> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Date: <u>SEP 26 2007</u> Heure Début: <u>4:10</u> Heure Fin: <u>4:20</u> Sceau:  </p> <p>Curing Début: <u>4:10</u> Curing Fin: <u>8:15</u></p>		
# Séq.: 28 0	Machine ou Opération: DÉMOULAGE 1	Description: DÉMOULAGE PIECE DART
 		
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs DÉMOULAGE DES PIÉCES</p> <p>Démouler la pièce en faisant bien attention de ne pas abimer les coins et le "edges".</p> <p>Sabler la surface de la pièce qui était en contact avec le le moule afin d'éliminer le fini lisse de celui-ci.</p> <p>Date: <u>SEP 27 2007</u> Heure Début: <u>3:30</u> Heure Fin: <u>3:55</u> Sceau: </p>		

Date: Vendredi, 2007-09-14 14:11:52  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd  
Numéro Job: 42165

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numero Job:



# Séq.: Machine ou Opération: Description :

29.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: SEP 27 2007 Heure Début: 3:35 Heure Fin: 4:00 Sceau: 6

30.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)

Dupont Primer N° 1104S

N° de Lot: 1-6149-1

31.0 AAC0670 Dupont Activation N° 7975S

Commentair Qty: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)

Dupont Activation N° 7975S

N° de Lot: 1-6254-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)

Dupont Reducer N° 12375S

N° de Lot: 1-6265-3

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

34.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PRÉPARATION DU MATÉRIEL DART








Appliquer une première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.

# Application primer

Laisser sécher pendant 3 heures.

Date: Vendredi, 2007-09-14 14:11:52  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 42165		Numéro Article: DKC134-0054	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Date: <u>04/10/07</u> Heure Début: <u>14h</u> Heure Fin: <u>16h</u> Sceau: _____			
35.0	FINITION 3	FINITION PIECE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIECE DART			
Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.			
36.0	ACC058	Polysoft 1.3 kg # 003012 Sikkens	
Commentaire Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) Polysoft 1.3 kg # 003012 Sikkens			
N° de Lot: <u>1-6284-1</u>			
37.0	ACC059	Durcisseur Polysoft #004000 Sikkens	
Commentaire Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s) Durcisseur Polysoft #004000 Sikkens			
38.0	FINITION 3	FINITION PIECE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs FINITION GÉNÉRALE			
Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.			
Date: <u>11/10/07</u> Heure Début: <u>12:30</u> Heure Fin: <u>15:00</u> Sceau: _____			
39.0	AAC0671	Dupont Primer N° 1104S	
Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s) Dupont Primer N° 1104S N° de Lot: <u>1-6149-1</u>			
40.0	AAC0670	Dupont Activator N° 7975S	
Commentaire Qty.: 0.2800 PINTe(s)/Unit Total : 0.2800 PINTe(s) Dupont Activator N° 7975S N° de Lot: <u>1-6149-3</u>			
41.0	AAC0672	Dupont Reducer N° 12375S	
Commentaire Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s) Dupont Reducer N° 12375S N° de Lot: <u>1-6149-3</u>			
42.0	PREPARATION 3	PREPARATION DU MATERIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs PRÉPARATION DU MATÉRIEL			
Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.			



Date: Vendredi, 2007-09-14 14:11:52  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42165

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:

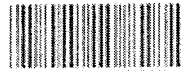


# Séq.: Machine ou Opération: Description :

43.0

PREPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
APPLICATION DE PRIMER

Appliquer une deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.

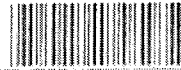
# Application de primer.

18-10-07 11:50 2:00  
Date: 18-10-07 Heure Début: 10:40 Heure Fin: 11:20 Sceau:

44.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
INSPECTION PIÈCE DART

Inspection des pièces par le département de la qualité

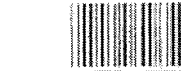
Quantité: 1 Date: 18-10-07 Sceau: DELAFAYE 95

Quantité: Date: Sceau:

45.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 18-10-07 Sceau: 11

Quantité: Date: Sceau:

Date: Wednesday, 10/10/2007 11:03:01 AM  
User: Kim Johnston

Process Sheet

46

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY RH
Job Number	: 35071B		
Estimate Number	: 12596		
P.O. Number	:	Part Number	: D31882M
This Issue	: 10/10/2007 S.O. No. :	Drawing Number	: D3188 REV.E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 33439A	Material	:
Written By	:	Due Date	: 11/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>AO 071010</u>		
Comment	: Est Rev:A New issue ecn882 06-11-30 EC est rev B rev D dwg 07.03.07 ec est rev C rev E dwg 07.04.16 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Ship To Delastek

8 D2213 Spacer

Batch: 30107

C207111112 (8)

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
Issue P/O: 4784  
Description: D3188-2M BODY  
SHIP: D2213 Spacers  
Supplier: Delastek  
Conformity Certificate and Process sheet required  
Ship 2 Items from Previous steps

C207110111  
(1)

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Receive and inspect for transit damage.Ensure a copy of certification of conformity and process sheet from Delastek is attached.

7-11-14 SQ (13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:03:01 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 35071B

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



*1412-060*



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*ml 07/12/07*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*①*

Comment: FINAL INSPECTION/W/O RELEASE

*12/12/13*

Job Completion



*min 2007/12/12*

*Wdf. 12-13*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b> SCALE NTS	
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

RELEASED

07.04.09

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:
  - RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
  - FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES
  - FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN
- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501
- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

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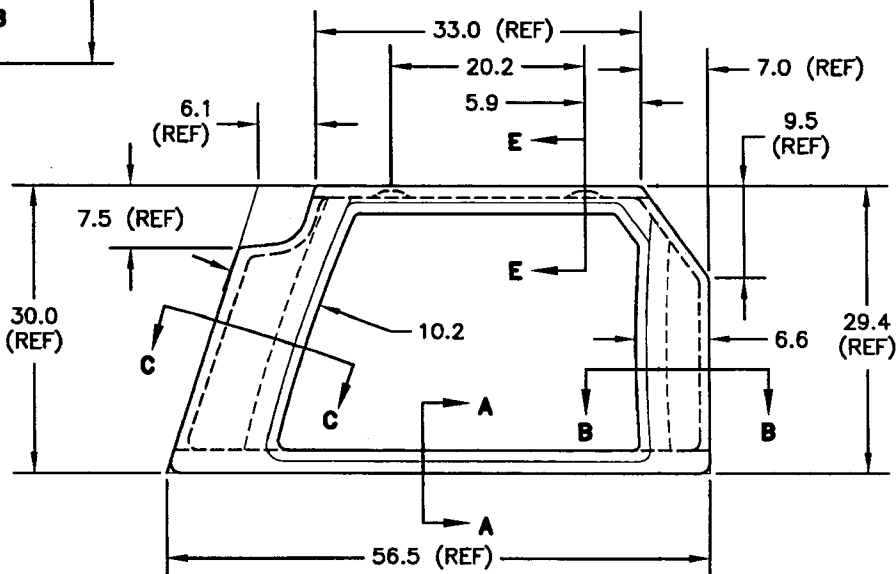
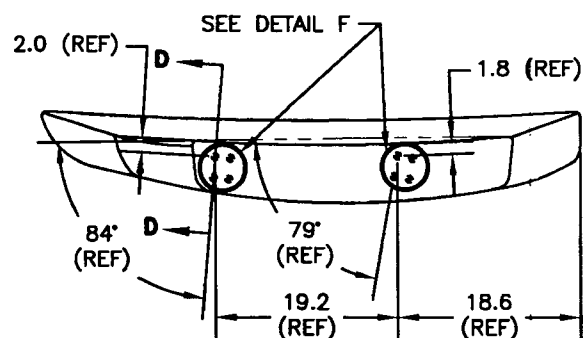
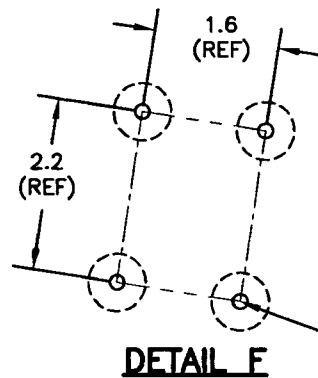
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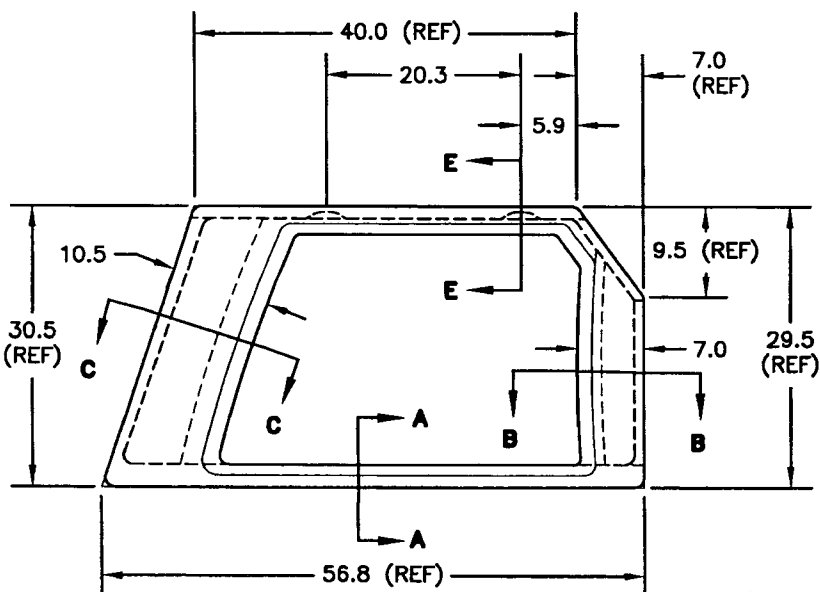
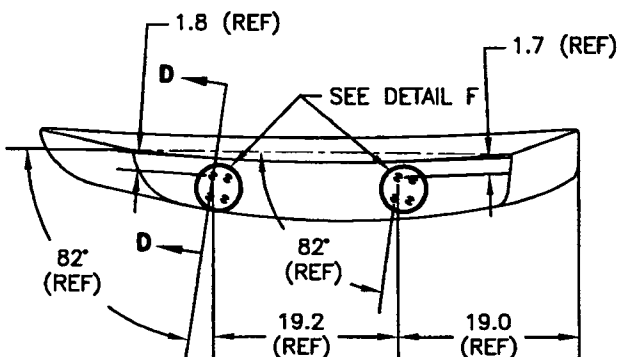
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07.04.02

INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-3M SPACEPOD BODY**



**D3188-1M SPACEPOD BODY**

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DATE	07.04.02	TITLE	SPACEPOD BODY	SHEET 2 OF 11
		SCALE	NTS	REV. E

**D3186-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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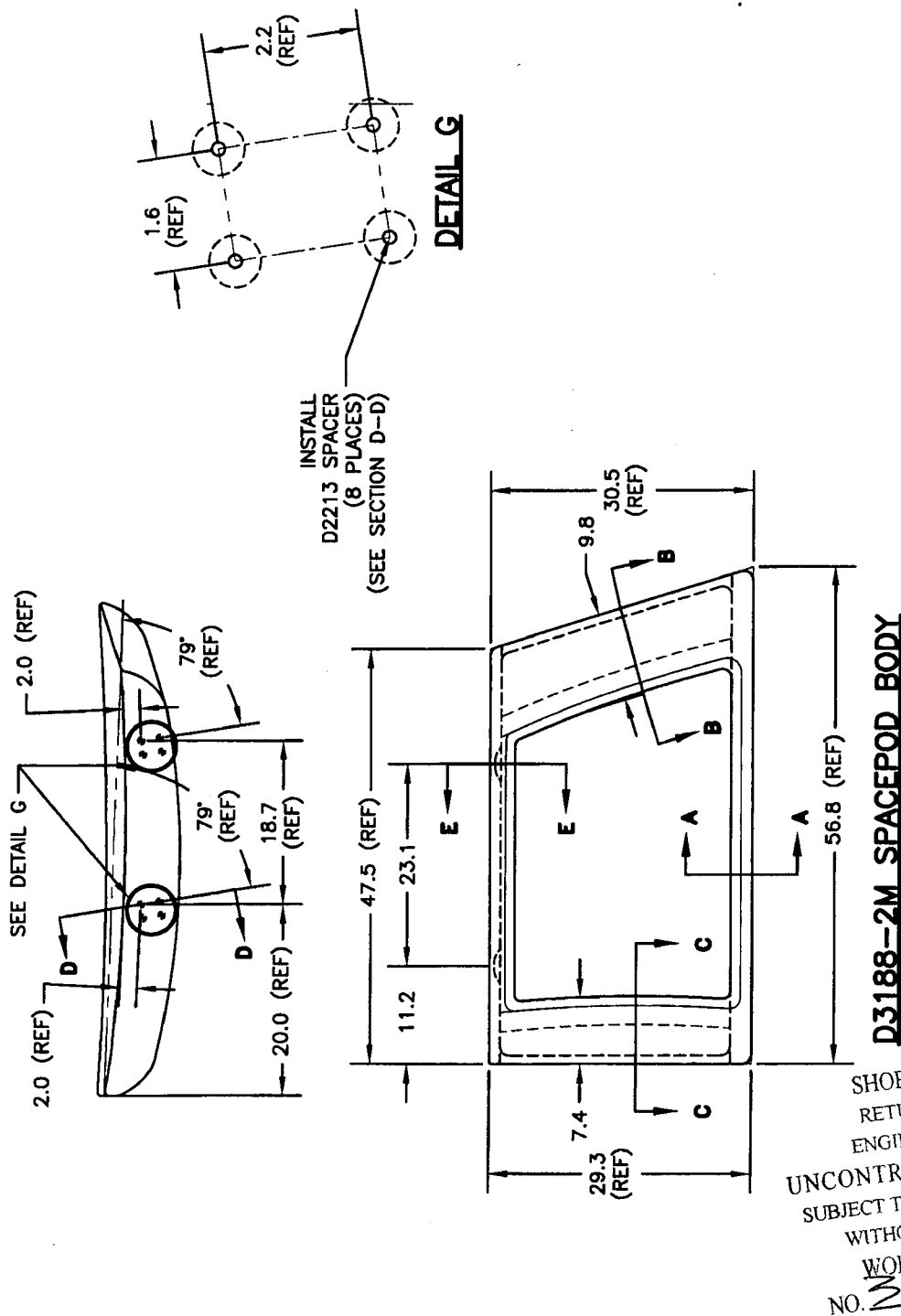
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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE <b>NTS</b>

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07.04.02



D3188-2M NOTES:  
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2) SEE SHEET #4 FOR SECTION VIEWS.

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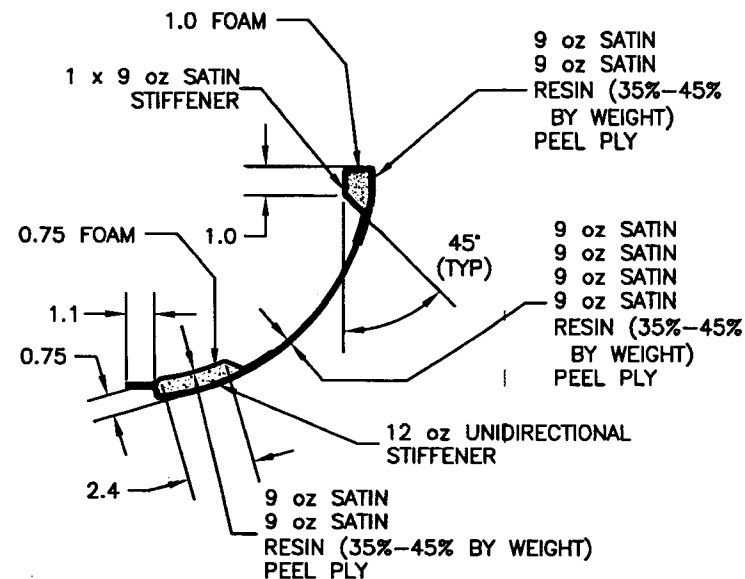
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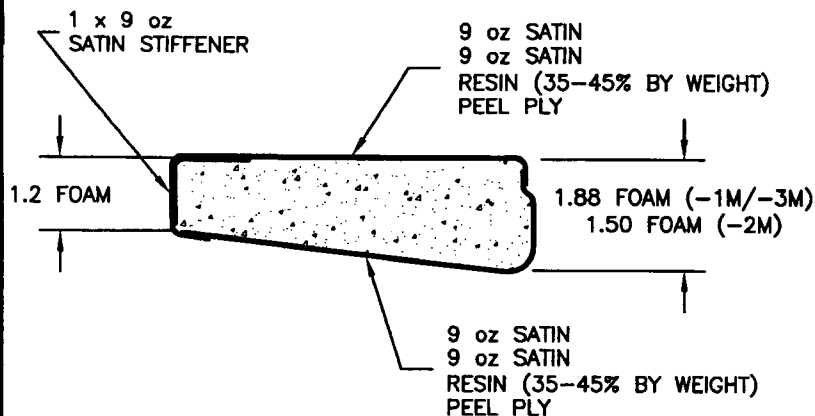
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		TITLE	SPACEPOD BODY	SHEET 4 OF 11
		SCALE	NTS	

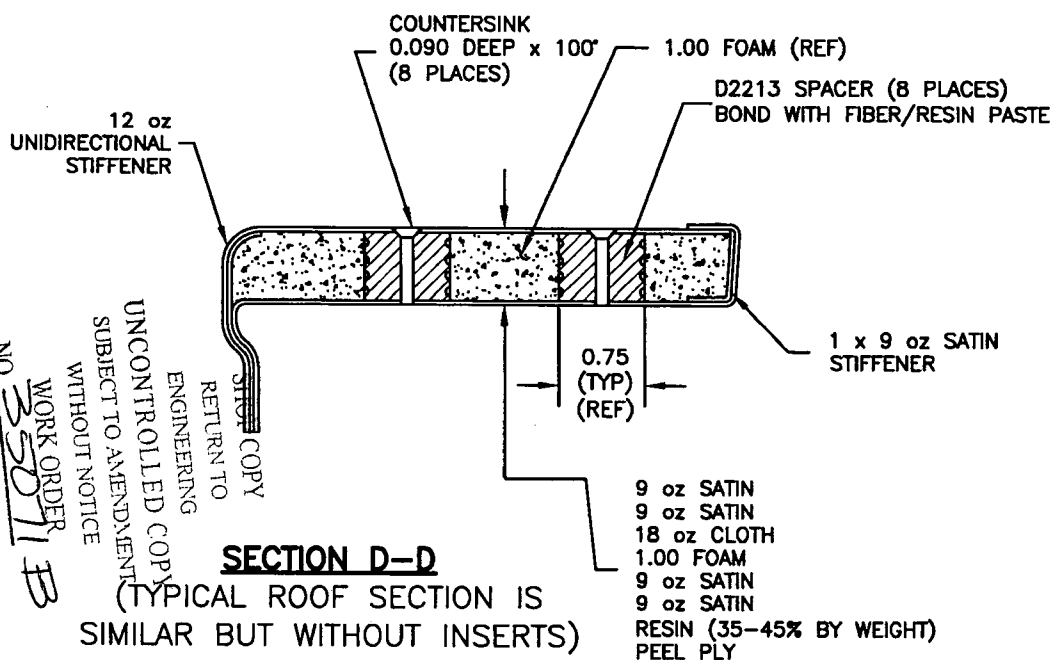
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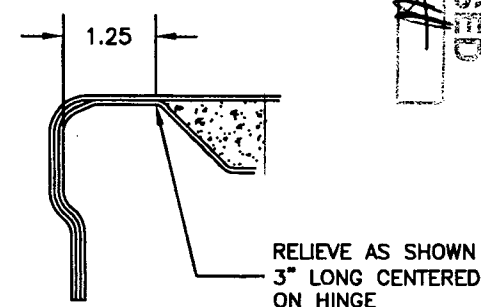
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)

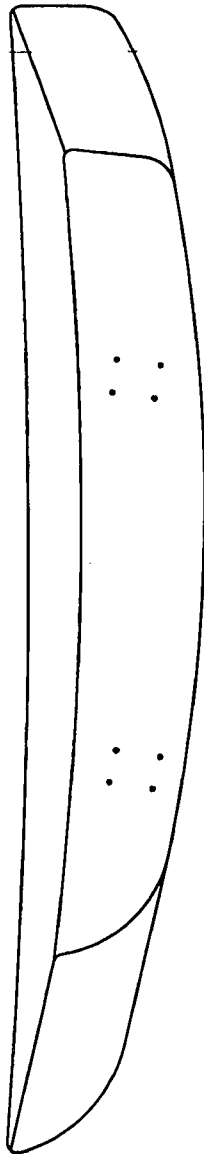


**SECTION E-E**  
(2 PLACES PER POD)

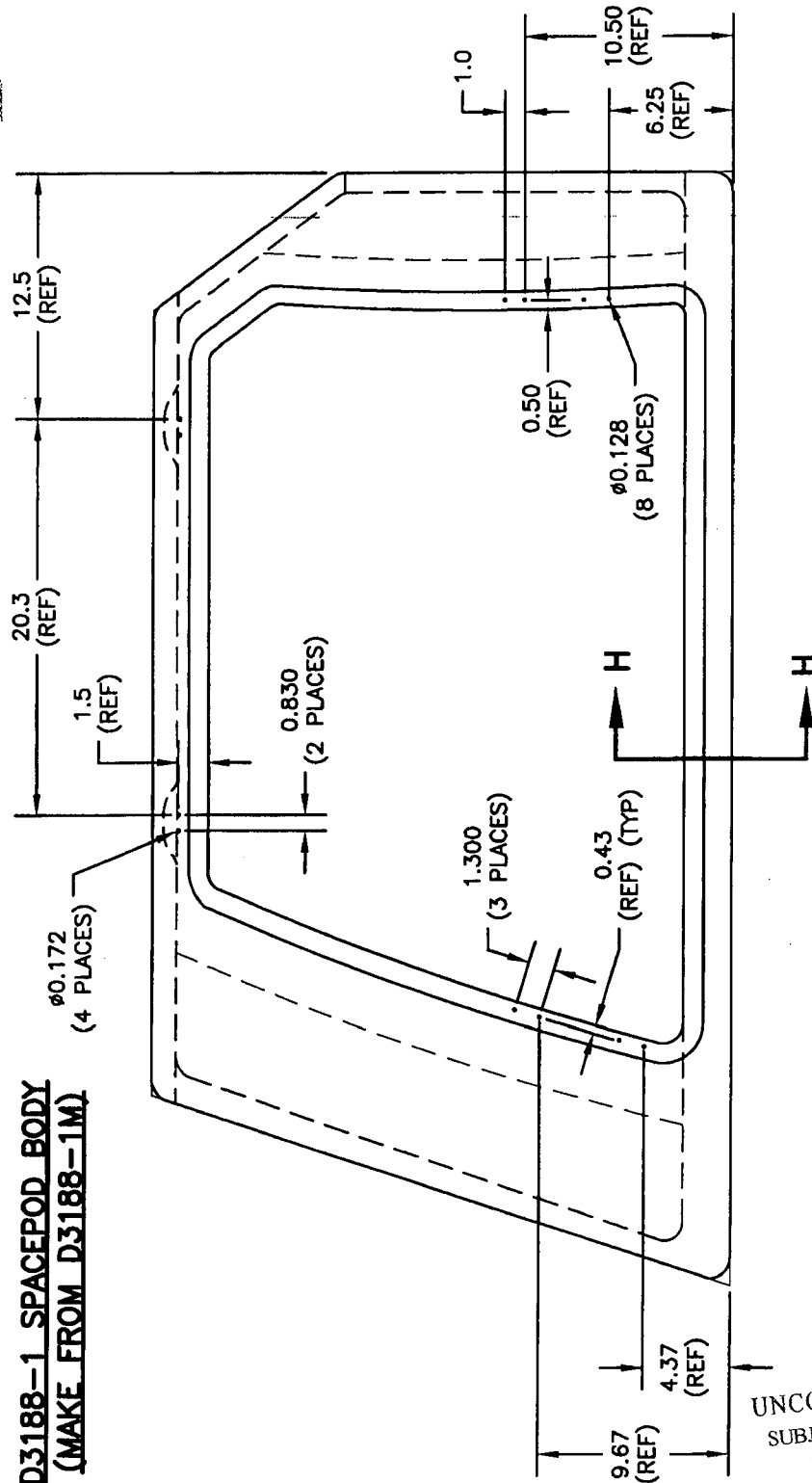


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**D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

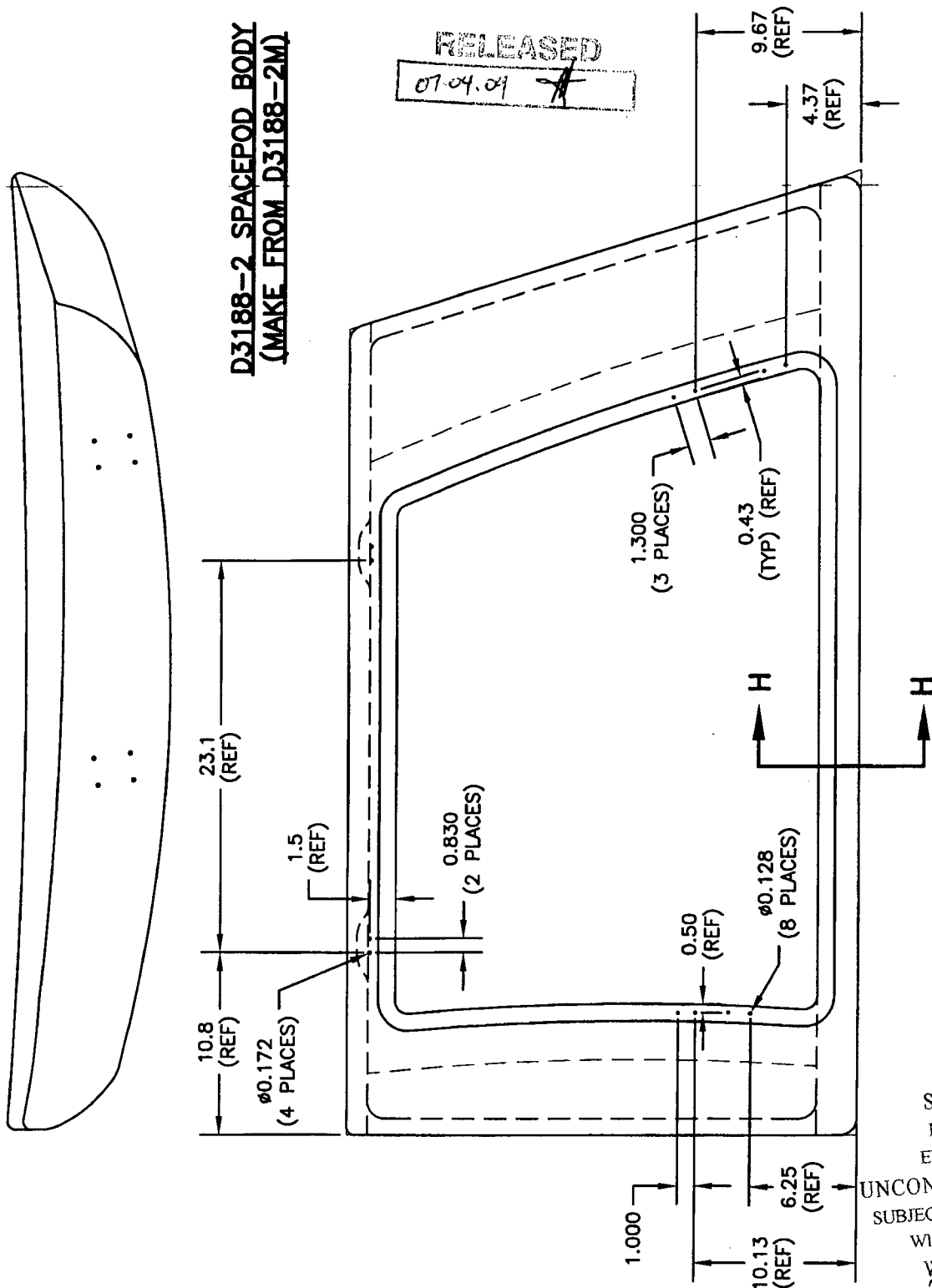
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DATE <b>07.04.02</b>	TITLE <b>SPACEPOD BODY</b>		SCALE <b>NTS</b>



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEW

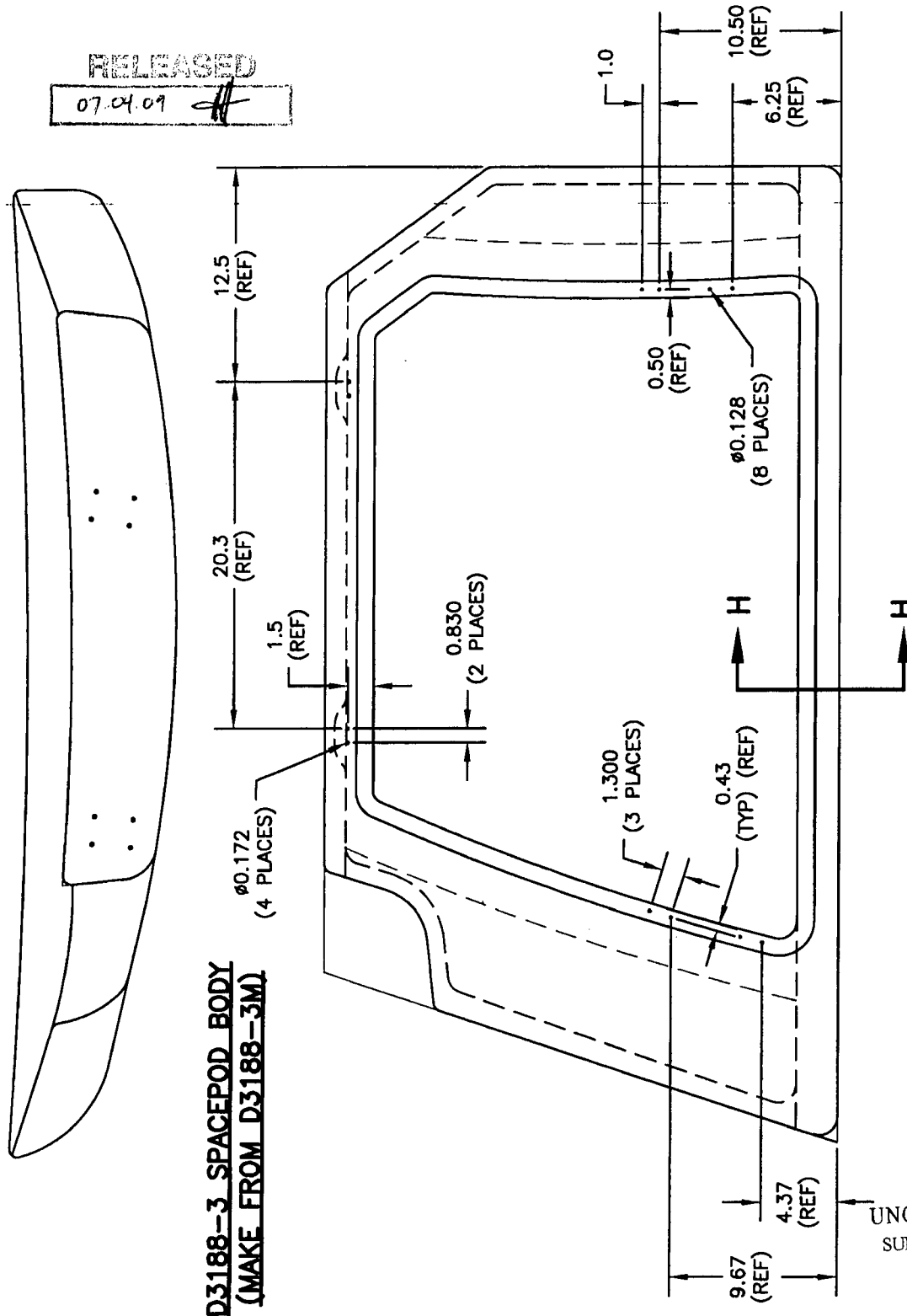
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**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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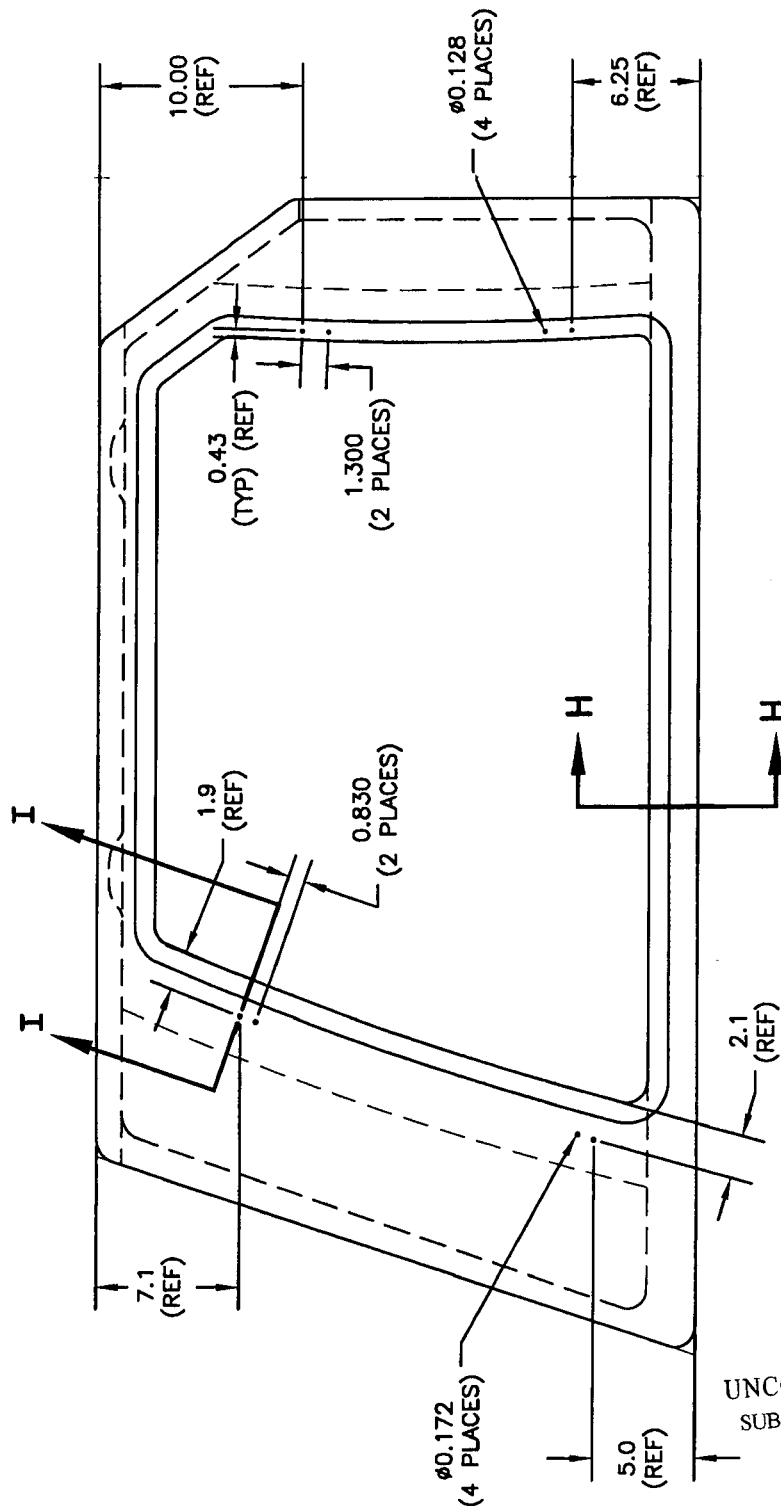
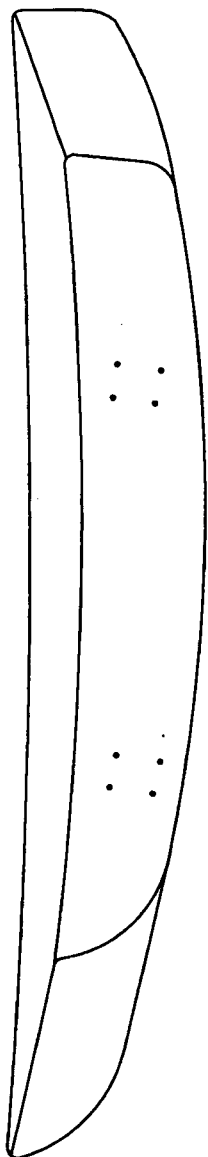


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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.02

D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

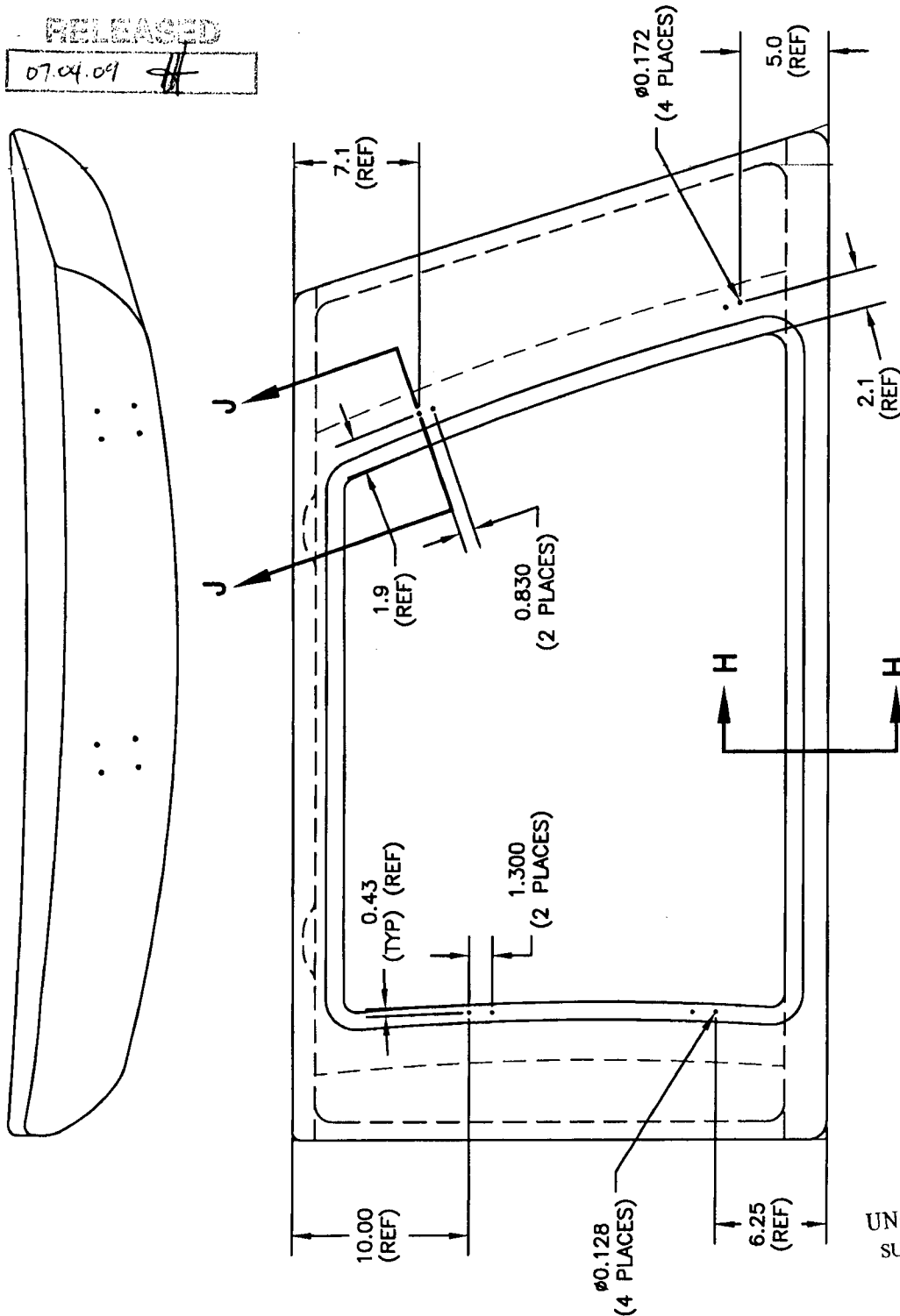
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



D3188--6 SPACEPOD BODY  
(MAKE FROM D3188--2M)

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186--4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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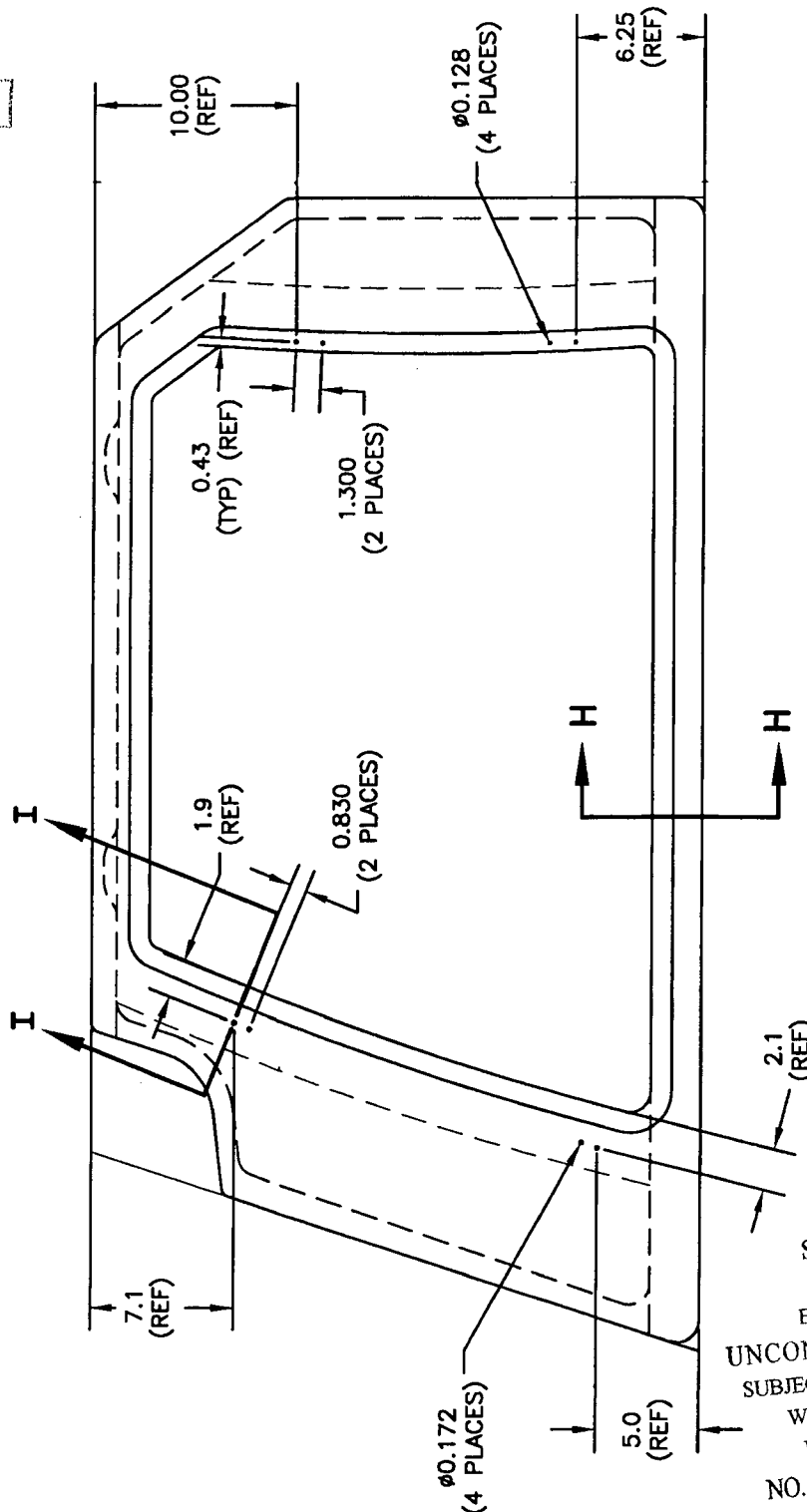
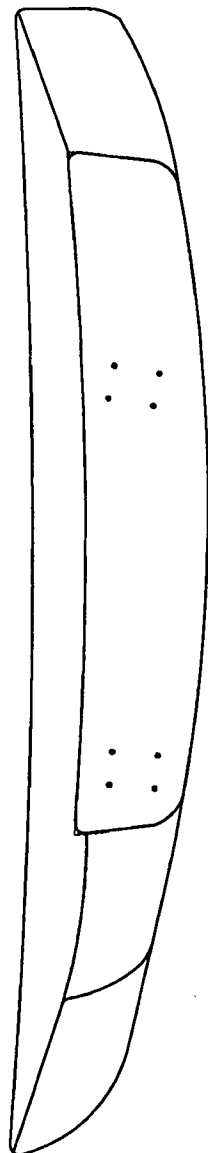
**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3188</b>	REV. E SHEET 10 OF 11
DATE <b>07.04.02</b>	TITLE <b>SPACEPOD BODY</b>		SCALE <b>NTS</b>

RELEASED

07.04.09

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



**NOTE:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. **35071B**

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DESIGN JB	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 11 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

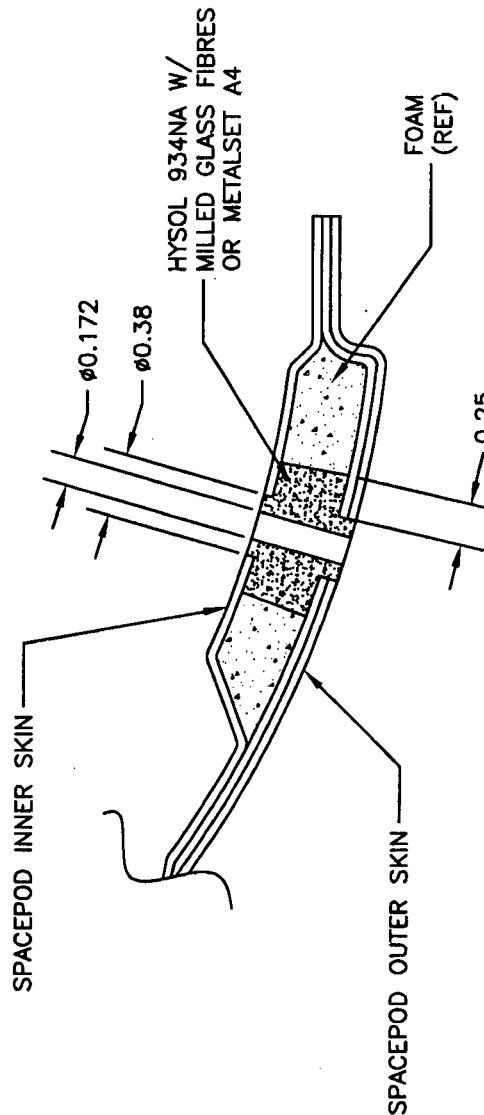
01.04.09 [Signature]

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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DELASTEI COMPOSITES INC.  
2699, Steeple Avenue  
Local 13, PORTE-AN  
Grand-Monac, Quebec G9T 1K7  
Can \*\*Fax (514) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12250-A
Customer #	DART

Telephone: (819) 533-5788  
Warehouse: MAIN

**Bill to:**

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

**Ship to:**

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-622-5200  
Contact: Linda Lucelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net 30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
13-11-2007	11-10-2007	5502	Chantal Lavoie	P000004784			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0653	D31881M Spacepod Body L.H. B35070B Dwg. Rev. F Job: 42167			
				U de M: Each			
1	0	1	DKC134-0652	D31861M Spacepod Door L.H. B35070C01 Dwg. Rev. D Job: 42140			
				U de M: Each			
1	0	1	DKC134-0654	D31862M Spacepod Door R.H. B35071C01 Dwg. Rev. D Job: 42165			
				U de M: Each			
1	0	1	DKC134-0655	D31882M Spacepod Body R.H. B35071B Dwg. Rev. I Job: 42166			
				U de M: Each			
							WB # 129-0601-8603-847.854

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:



Quality department AQ-557

Date: 2007-09-14 14:11:55  
 Utilisateur: Marc Dubé

## Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD BODY R/H
Numéro Job :	42166	Numéro Article :	DKC134-0055
Numéro Soumission :	2587	Numéro Dessin :	D3188
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-09-14 No. B.V. :	Révision dessin :	E
Prsht Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Prem. fois :	- - Type :	Date Due :	2007-09-21 Qté: 1 Udm: UNITE
Job précédente :	42143		

Écrit par : \_\_\_\_\_  
 Vérifié & Approuvé par : \_\_\_\_\_  
 Commentaires : N° de pièce Dart Aerospace : D31882M

Process Sheet Rev. 03 Changer la révision de dessin de C @ E

Produit additionnel

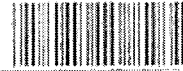
Numéro Job:



# Séq.: Machine ou Opération: Description :

 1.0 AC0303 Frekote 44NC  
 Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
 Frekote 44NC

2.0 PREPARATION 3 PREPARATION DU MATERIEL DART


 Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le OSI-006.

Date: 25-09-07 Heure Début: 8:30 Heure Fin: 8:55 Scéau: 32

 3.0 AC0409 Tissu à délaminer Release ply B  
 Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)  
 Tissu à délaminer Release ply B

 4.0 AC0407 Wrightlon 5200 Bleu P3  
 Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)  
 Wrightlon 5200 Bleu P3

 5.0 AC0408 Feutre de drainage N° Airweave N 10  
 Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)  
 Feutre de drainage N° Airweave N 10

 6.0 AC0752 Stretchlon 200 poche à vide Vert  
 Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)  
 Stretchlon 200 poche à vide Vert

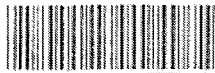
Date: Vendredi, 2007-09-14 14:11:55  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42166

Nom Dessin: SPACEPOD BODY R/H  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish
Commentaire Qty.: 11.400 VERGE(s)/Unit Total: 11.400 VERGE(s) 9.7 oz Weave #FG-778150-125Y Volan Finish		

8.0	AAC0443	Fiberglass 12 oz Unidirectional
Commentaire Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s) Fiberglass 12 oz Unidirectional N° de Lot: 1-5964-1		

9.0	AAC0633	WR1850 ROVING 18 OZ x 50"
Commentaire Qty.: 0.35 VERGE(s)/Unit Total: 0.35 VERGE(s) WR1850 ROVING 18 OZ x 50" N° de Lot: 1-6113-3		

10.0	AAC0098	Ruban à gommer jaune #: T/AT-200Y
Commentaire Qty.: 4.0000 RL(s)/Unit Total: 4.0000 RL(s) Ruban à gommer jaune #: T/AT-200Y		

11.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs  
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

03-08-07  
Date: Heure Début: 12:30 Heure Fin: 4:30 Sceau: 32

12.0	AAC0275	Catalyst N° DDM-9
Commentaire Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s) Catalyst N° DDM-9 N° de Lot: 1-6118-3		

13.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total: 2.000 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6330-1		

14.0	AAC0673	Fibre de verre Miapoxy 66
Commentaire Qty.: 0.0039 GALLON(s)/Unit Total: 0.0039 GALLON(s) Fibre de verre Miapoxy 66		

N° de Lot: 1-5951-1

15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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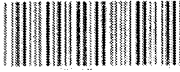




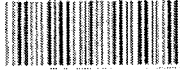





Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Vendredi, 2007-09-14 14:11:55  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd. Numéro Job: 42186.	Nom Dessin: SPACEPOD BODY R/H Numéro Article: DKC134-0055	
Numéro Job 		
# Séq.: 16.0	Machine ou Opération: LAMINAGE	Description: LAMINAGE PIÈCE DART
Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66 Date: <u>26-09-07</u> Heure Début: <u>8:05</u> Heure Fin: <u>8:15</u> Sceau: 		
 		
Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs FAIRE LE LAMINAGE DES TISSUS  À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.  À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.  Laminage du 12 oz.  Recommencer l'opération pour le deuxième pli. Date: <u>26-09-07</u> Heure Début: <u>8:15</u> Heure Fin: <u>9:20</u> Sceau:   		
17.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
 		
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs EFFECTUER LA POCHE A VIDE  Faire la poche à vide en appliquant les composantes dans l'ordre suivant:  1- Tissu à délaminer, 2- Film perforé P-3, 3- Feutre de drainage 4- Sac à vide Stretchlon 200  Laisser sécher pendant 4 heures minimum. Date: <u>26-09-07</u> Heure Début: <u>9:20</u> Heure Fin: <u>9:30</u> Sceau:    Curing Début: <u>9:20</u> Curing Fin: <u>8:00</u>		
18.0	AAC0457	ATC core-cell A500 plait 4'x8' 1" thick
Commentaire Qty: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s) ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart  N° de Lot: <u>3-5915-2</u>		

Date: Vendredi, 2007-09-14 14:11:55  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42165

Nom Dessin: SPACEPOD BODY RH  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description:

19.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run: 2.0000Hrs  
TAILLAGE DU MATÉRIEL

Tailler le Foam Core 1" selon le plan de découpe et les gabarits

Date: SEP 27 2007 Heure Début: 11:40 Heure Fin: 12:56 Sceau:



20.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total: 0.200 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6330-1

21.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0064 PINTE(s)/Unit Total: 0.0064 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3

22.0

FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
FINITION PIÈCE DART

Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.

23.0

AAC0452

Polybond B46F

Commentaire Qty.: 0.010 KIT(s)/Unit Total: 0.010 KIT(s)  
Polybond B46F

N° de Lot: 1-6253-1

24.0

FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
FINITION PIÈCE DART

À l'aide du Polybond, coller ensemble les deux surfaces scellées

Disposer des point sur les pièces pour conserver une pression de collage.












Laisser sécher pour un minimum de deux heures.

Quantité: / Date: SEP 28 2007 Sceau:



Date: Vendredi, 2007-09-14 14:11:55  
Utilisateur: Marc Dubé

### Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42166		Numéro Article: DKC134-0055	
Numéro Job:			
# Ség.:	Machine ou Opération:	Description :	
Quantité: _____ Date: _____ Sceau: _____			
25.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs TRIMAGE COMPOSITES DART			
Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.			
Quantité: <u>1</u> Date: <u>SEP 28 2007</u> Sceau:  			
Quantité: _____ Date: _____ Sceau: _____			
26.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.			
N° de Lot: <u>1-6330-1</u>			
27.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s) Catalyst N° DDM-9			
N° de Lot: <u>1-6118-3</u>			
28.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs PRÉPARATION DU MATÉRIEL DART			
Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promu 75 minutes..			
29.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 20.0000Hrs FABRICATION GÉNÉRALE PLASTIC COMMERCIAL			
Retirer les pièces de foam core du moule			
Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G.# Sceller le foam Core.			
Laisser sécher pendant 2 heures minimum.			
Date: <u>SEP 28 2007</u> Sceau:   Initiales: <u>C.G. N.T.</u>			

Date: Vendredi, 2007-09-14 14:11:55  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42166

Nom Dessin: SPACEPOD BODY R/H  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description:

30.0 AAC0452 Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)

Polybond B46F

N° de Lot:

1-6253-1

31.0 PREPARATION 3 PREPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation du Poly bond.

Date: 09-10-07 Heure Début: 12:35 Heure Fin: 12:50 Sceau:



32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

ASSEMBLAGE GÉNÉRALE DES PIÉCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: 09-10-07 Heure Début: 12:50 Heure Fin: 1:15 Sceau:



33.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs

EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date: 09-10-07 Heure Début: 1:15 Heure Fin: 1:25 Sceau:











Curing Début: 1:15 Curing Fin:

Date: Vendredi, 2007-09-14 14:11:55

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42165		Numéro Article: DKC134-0055	
Numéro Job:			
# Seq.:	Machine ou Opération:	Description :	
34.0	AC0058	Polysoft 1.3 kg # 003012 Sikks	
Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s) Polysoft 1.3 kg # 003012 Sikks			
N° de Lot: <u>1-6284-1</u>			
35.0	AC0059	Durcisseur Polysoft #004009 Sikks	
Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s) Durcisseur Polysoft #004009 Sikks			
36.0	FINITION 3	FINITION PIECE DART	
			
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs FINITION GÉNÉRALE			
Corriger les petits défauts de surface de la pièce avec du Sikks. Pour les plus gros défauts utiliser du polybond			
Date: <u>8/10/07</u> Heure Début: <u>2:00</u> Heure Fin: <u>3:00</u> Sceau: <u>MA</u> 			
37.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs TRIMAGE COMPOSITES DART			
Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.			
38.0	AAC0324	Resine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.			
N° de Lot: <u>1-6330-1</u>			
39.0	AAC0275	Catalyst N° DDM-9	
Commentair Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s) Catalyst N° DDM-9			
N° de Lot: <u>1-6118-3</u>			
40.0	FINITION 3	FINITION PIECE DART	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÉCE DART			
Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core			
Laisser sécher pendant minimum deux heures.			



Date: Vendredi, 2007-09-14 14:11:56  
Utilisateur: Marc Dubé

### Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42166

Nom Dessin: SPACEPOD BODY R/H  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description:

41.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0504 PINTÉ(s)/Unit Total: 0.0504 PINTÉ(s)  
Catalyst N° DDM-9

N° de Lot: 1-6/18-3

42.0 AAC0324 Résine (411B7530) 411-350 promo. 75min

Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total: 1.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6330-1

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 18/6/07 Heure Début: 8:15 Heure Fin: 8:22 Sceau:

44.0 INSPECTION 3 INSPECTION PIÉCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs  
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: 18/6/07 Heure Début: 8:50 Heure Fin: 10:00 Sceau:



45.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs  
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:



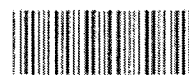


- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: Vendredi, 2007-09-14 14:11:56






Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42166		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Date: 18-10-07		Heure Début: 10:00	Heure Fin: 10:10
Curing Début: 8:00		Curing Fin: 10:10	
46.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs DÉMOULAGE DES PIÈCES  Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.  Date: 23/10/07			
47.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs TRIMAGE DE FINITION  Perçer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.  Par l'intérieur, perçer les 8 dégagement de ø .745" pour les spacers N° D2213 ( ne pas perçer la peau extérieure de la pièce )  Date: 23/10/07			
48.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s) Catalyst N° DDM-9  N° de Lot: 1-6/18-3			
49.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.  N° de Lot: 1-6380-1			
50.0	AAC0673	Fibre de verre Mlapoxy 66	
Commentaire Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s) Fibre de verre Mlapoxy 66  N° de Lot: 3MK20			





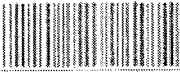


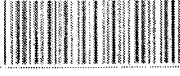
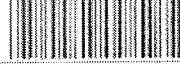
Date: Vendredi, 2007-09-14 14:11:56  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42186		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
51.0	PREPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL</p> <p>Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.</p> <p>Date: <u>23/10/07</u> Heure Début: <u>11:00</u> Heure Fin: <u>11:12</u> Sceau: <u>  </u></p>			
52.0	AAC0448	Spacer N° D2213	
<p>Commentaire Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s) Spacer N° D2213 N° de Lot: <u>1-6375-4</u></p>			
53.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs ASSEMBLAGE GÉNÉRALE DES PIECES</p> <p>Faire l'assemblage des inserts ( Spacer ) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre courte Mirapoxy 66.</p> <p>Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous</p> <p>Appliquer un pression sur les pièces de 9 oz à l'aide d'un bloc de bois et de pinces autobloquantes</p> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Date: <u>23/10/07</u> Heure Début: <u>11:10</u> Heure Fin: <u>11:30</u> Sceau: <u>  </u></p> <p>Curing Début: <u>11:00</u> Curing Fin: <u>5:00</u></p>			
54.0	AAC0275	Catalyst N° DDM-9	
<p>Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-6118-1</u></p>			
55.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<p>Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-6330-1</u></p>			

Date: Vendred, 2007-09-14 14:11:56  
Utilisateur: Marc Dubé








## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42166		Numéro Article: DKC134-0056	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
56.0	PREPARATION 3	PREPARATION DU MATERIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL			
Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.			
Date: <u>23/6</u> Heure Début: <u>3:15</u> Heure Fin: <u>3:20</u> Sceau: 			
57.0	LAMINAGE	LAMINAGE PIECE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs FAIRE LE LAMINAGE DES TISSUS			
Retirer les pinces et blocs de bois			
Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièces. Selon le dessin.			
Laisser sécher pendant 4 heures minimum.			
Date: <u>24/6</u> Heure Début: <u>3:20</u> Heure Fin: <u>3:30</u> Sceau: 			
Curing Début: <u>3:20</u> Curing Fin: <u>5:20</u>			
58.0	FINITION 3	FINITION PIECE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÉCE DART			
Repercer les 8 trous des spacers afin de les déboucher			
Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections. <u>25/1007 MA</u>			
59.0	AAC0671	Dupont Primer N° 1104S	
Commentaire Qty.: 0.5000 GALLON(s)/Unit Total: 0.5000 GALLON(s) Dupont Primer N° 1104S			
N° de Lot: <u>1-6282-1</u>			
60.0	AAC0670	Dupont Activator N° 7975S	
Commentaire Qty.: 1.0000 PINTE(s)/Unit Total: 1.0000 PINTE(s) Dupont Activator N° 7975S			
N° de Lot: <u>1-6149-3</u>			

Date: Vendredi, 2007-09-14 14:11:56

Utilisateur: Marc Dubé











## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42166		Numéro Article: OKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
61 0	AAC0672	Dupont Reducer N° 12375S	
Commentaire Qty.: 0.1250 GALLON(s)/Unit Total: 0.1250 GALLON(s) Dupont Reducer N° 12375S			
N° de Lot: 1-5682-2			
62 0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs PRÉPARATION DU MATÉRIEL DART			
Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.			
63 0	PEINT/ PRIMER2	PEINTURE / PRIMER DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs PEINTURE / PRIMER DART			
Appliquer une couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon I.G. # Application du primer			
Laisser sécher pendant 3 heures minimum			
Date: 25/10/07 Heure Début: 3:50 Heure Fin: 4:10 Sceau: 479			
64 0	AC0058	Polysoft 1.3 kg # 003012 Sikkens	
Commentaire Qty.: 0.020 UNITE(s)/Unit Total: 0.020 UNITE(s) Polysoft 1.3 kg # 003012 Sikkens			
N° de Lot: 1-6284-1			
65 0	AC0059	Durcisseur Polysoft #004009 Sikkens	
Commentaire Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s) Durcisseur Polysoft #004009 Sikkens			
66 0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs FINITION GÉNÉRALE			
Faire les réparations de finition s'il y a lieu à l'aide du Sikkens			
Faire un léger sablage ( Grit 220 ) de toute les surfaces.			
Date: 26/10/07 Heure Début: 8:15 Heure Fin: 11:00 Sceau: 477			

Date: Vendredi 2007-09-14 14:11:56

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42166		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
67.0	AAC0671	Dupont Primer N° 1104S	
Commentair Qty.: 0.2500 GALLON(s)/Unit Total: 0.2500 GALLON(s) Dupont Primer N° 1104S N° de Lot: <u>1.6282-1</u>			
68.0	AAC0670	Dupont Activator N° 7975S	
Commentair Qty.: 0.5000 PINTE(s)/Unit Total: 0.5000 PINTE(s) Dupont Activator N° 7975S N° de Lot: <u>1.6149-3</u>			
69.0	AAC0672	Dupont Reducer N° 12375S	
Commentair Qty.: 0.0625 GALLON(s)/Unit Total: 0.0625 GALLON(s) Dupont Reducer N° 12375S N° de Lot: <u>1.5692-2</u>			
70.0	PREPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs PRÉPARATION DU MATÉRIEL			
Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.			
71.0	PEINT/PRIMER2	PEINTURE / PRIMER DART	
			
Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs APPLICATION DE PRIMER			
Appliquer deux couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.			
Laisser sécher pendant 3 heures minimum			
Date: <u>26/09</u> Heure Début: <u>3 30</u> Heure Fin: <u>3 50</u> Sceau: <u>M. J.</u>			
72.0	INSPECTION 3	INSPECTION PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs INSPECTION GÉNÉRALE			
Faire l'inspection générale de la pièce selon le dessin par le département de la qualité			
Date: <u>30/10/07</u> Sceau:  Initiales: <u>JS</u>			
73.0	EMBALLAGE 3	EMBALLAGE PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs EMBALLAGE PIÈCE DART			
Faire l'emballage dans le contenant approprié.			

Date: Vendredi, 2007-09-14 14:11:56  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42166

Nom Dessin: SPACEPOD BODY R/H  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 30-10-07 Sceau: (Signature)

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_